

**(19) World Intellectual Property Organization
International Bureau**



(43) International Publication Date
14 November 2002 (14.11.2002)

(10) International Publication Number
WO 02/089719 A1

PCT

(51) International Patent Classification⁷: **A61F 13/02**

(21) International Application Number: PCT/US02/09221

(22) International Filing Date: 26 March 2002 (26.03.2002)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data: 09/847,941 2 May 2001 (02.05.2001) US

(71) Applicant: 3M INNOVATIVE PROPERTIES COMPANY [US/US]; 3M Center, Post Office Box 33427, Saint Paul, MN 55133-3427 (US).

(72) Inventor: DUNSHEE, Wayne, K.; Post Office Box 33427, Saint Paul, MN 55133-3427 (US).

(74) Agents: GWIN, Doreen, S., L. et al.; Office of Intellectual Property Counsel, Post Office Box 33427, Saint Paul, MN 55133-3427 (US).

(81) Designated States (national): AE, AG, AL, AM, AT (utility model), AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ (utility model), CZ, DE (utility model), DE, DK (utility model), DK, DM, DZ, EC, EE (utility model), EE, ES, FI (utility model), FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD,

SE, SG, SI, SK (utility model), SK, SL, TJ, TM, TN, TR,
TT, TZ, UA, UG, UZ, VN, YU, ZA, ZM, ZW.

(84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

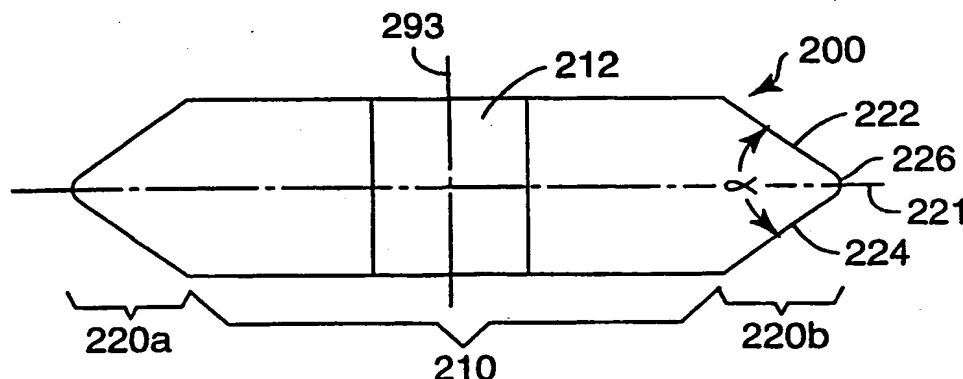
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii)) for the following designations AF, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MY, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZM, ZW, ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)
- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii)) for all designations

Published:

— with international search report

[Continued on next page]

(54) Title: TAPERED STRETCH REMOVABLE ADHESIVE ARTICLES AND METHODS



(57) Abstract: Pressure sensitive adhesive articles and methods, particularly stretch removable adhesive articles that are preferably for use in adhering to skin or like delicate surfaces. The articles include tapered terminal portions to control release characteristics. Preferably, stretch removability of the article occurs as a result of the selection of a stretch removable pressure sensitive adhesive. In some embodiments of the articles and methods, the adhesive and backing delaminate upon removal. In other embodiments of the articles and methods, the backing includes a predefined tab located in a central location of the backing.



— *entirely in electronic form (except for this front page) and available upon request from the International Bureau*

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

TAPERED STRETCH REMOVABLE ADHESIVE ARTICLES AND METHODS

5 The invention relates to pressure sensitive adhesive products, particularly stretch removable adhesive articles with tapered terminal portions. Preferably, such articles are for use in adhering to skin or like delicate surfaces. Stretch removability occurs as a result of the selection of a stretch removable adhesive, i.e., one that has sufficient internal strength that it can be gripped and removed
10 on its own even in the absence of a backing, or as a result of the selection of a stretch removable backing, i.e., a backing that allows a construction that includes a weaker adhesive to be removed by stretching.

 Pressure sensitive adhesive tapes and the like are used in a wide variety of applications where there is a need to adhere to skin, for example, medical
15 tapes, wound or surgical dressings, athletic tapes, surgical drapes, or tapes or tabs used in adhering medical devices such as sensors, electrodes, ostomy appliances, or the like. A concern with all these adhesive-coated products is the need to balance the objective of providing sufficiently high levels of adhesion to ensure that the pressure sensitive adhesive products do not fall off, while
20 ensuring that the underlying skin or other delicate surface experiences a low amount of trauma, damage, or irritation during use and/or removal. These goals are generally conflicting. Many approaches have been suggested to balance these conflicting goals; however, there still remains a need for products that effectively do so.

25 For example, film-backed, normally tacky, pressure sensitive adhesive tapes that are highly stretchy and elastic are known that can be easily removed from a surface by stretching the tapes lengthwise in a direction substantially parallel to the plane of the surface. For such tapes the adhesion capability substantially disappears as the film is being stretched. If such tapes are too
30 elastic, they may exhibit large recoil when the stretching force is removed, which can be undesirable. Additionally, highly elastic tapes tend to substantially recover their original shape when the stretching force is removed, and they are

therefore not useful for indication of tampering or for guaranteeing single uses for hygienic purposes.

Such so-called "stretch release" or "stretch removable" adhesive constructions include backings having stretchabilities that typically match those of the adhesives. Other backings of differing stretchability can be used by using a pre-treated/damaged backing having a strength that is inconsequential in the stretch removal process and an adhesive that is substantial enough to alone support the stretch removal process, i.e., a stretch removable adhesive. Although many of such constructions are useful, there is still a need for stretch removable adhesive articles, particularly those that can be easily removed from a surface such as skin or other delicate surface without a significant amount of pain, trauma, damage, or irritation.

Summary of the Invention

The present invention provides methods and stretch removable adhesive articles that include a backing and a pressure sensitive adhesive layer disposed thereon. The backing includes a central portion and a plurality of tapered terminal portions extending outwardly from the central portion.

The tapered terminal portions may provide control over the release properties of the article to a surface, e.g., skin. Such control may be especially helpful as the stretch removable adhesive article reaches the point of complete detachment from a surface. It is at that point that the adhesive forces on the substrate may be acting in shear and it may be desired to limit shear forces on some substrates, e.g., skin and other shear-sensitive surface.

In one aspect, the present invention provides a medical article including a backing with a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions tapers towards a tip located distal from the central portion, wherein each terminal portion of the plurality of terminal portions includes two edges leading to the tip, the two edges defining an included angle of about 90 degrees or less; and a stretch removable pressure sensitive adhesive layer disposed on the backing. Also included are methods of removing the medical articles that include grasping

the central portion of the medical article and stretching to release the medical article. Methods of making the medical articles are also described.

5 In another aspect, the present invention provides a medical article including a backing with a plurality of terminal portions extending outwardly from a central portion and a stretch removable pressure sensitive adhesive layer disposed on the backing. Each terminal portion of the plurality of terminal portions includes a longitudinal axis, a tip located distal from the central portion of the backing along the longitudinal axis, and a maximum width measured perpendicular to the longitudinal axis. Further, each terminal portion of the
10 plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions has a setback width measured at a setback distance of 5 millimeters towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 10 millimeters or less when measured perpendicular to the longitudinal axis, and further wherein the
15 setback width is about 2.5 millimeters or more when measured perpendicular to the longitudinal axis. Also included are methods of removing the medical articles that include grasping the central portion of the medical article and stretching to release the medical article. Methods of making the medical articles are also described.

20 In another aspect, the present invention provides a medical article including a backing with a plurality of terminal portions extending outwardly from a central portion and a stretch removable pressure sensitive adhesive layer disposed on the backing. Each terminal portion of the plurality of terminal portions includes a longitudinal axis, a tip located distal from the central portion
25 of the backing along the longitudinal axis, and a maximum width measured perpendicular to the longitudinal axis. Further, each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions has a setback width measured at a setback distance that is 25% of the maximum width towards the central portion
30 from the tip along the longitudinal axis, wherein the setback width is about 60% or less of the maximum width when measured perpendicular to the longitudinal axis, and further wherein the setback width is about 10% or more of the

maximum width when measured perpendicular to the longitudinal axis. Also included are methods of removing the medical articles that include grasping the central portion of the medical article and stretching to release the medical article. Methods of making the medical articles are also described.

5 Preferably, the adhesive itself is stretch removable. Preferably, the adhesive is one that is suitable for use on skin and the adhesive article is in the form of a medical article, such as medical tapes, wound or surgical dressings, athletic tapes, surgical drapes, tapes or tabs used in adhering medical devices such as sensors, electrodes, ostomy appliances, and the like.

10 In one general embodiment, the backing and adhesive are selected such that they delaminate upon removal from skin (or similar delicate surface). Typically and preferably, this involves selecting the backing and adhesive such that the stretchability of the adhesive layer is greater than that of the backing under the same tension. In another general embodiment, the backing includes a
15 predefined tab (i.e., handle) located in a central portion of the backing, which can be used in a wide variety of adhesive articles, whether for medical or nonmedical uses.

 More specifically with respect to one of the general embodiments, the present invention provides methods of removal, methods of making, and medical
20 articles that delaminate upon removal from skin. One removal method involves: providing a medical article adhered to skin, wherein the medical article includes a backing and a stretch removable pressure sensitive adhesive layer disposed thereon; and stretching the medical article in an amount sufficient to delaminate the adhesive layer from the backing and remove the medical article from the
25 skin. Preferably, stretching the medical article includes stretching it in a direction substantially parallel to the plane of the skin to which it is adhered. Preferably, the backing and adhesive are selected such that the stretchability at break of the adhesive layer is greater than that of the backing under the same tension, and more preferably, at least about 10% greater.

30 Another method of removing a medical article from skin that delaminates upon removal includes: providing a medical article adhered to skin, wherein the medical article includes a backing and a stretch removable pressure sensitive

adhesive layer disposed thereon; and stretching the medical article in an amount sufficient to delaminate the adhesive layer from the backing and remove the medical article from the skin. In this embodiment: the backing and the adhesive layer are selected such that the stretchability of the adhesive layer is greater than
5 that of the backing under the same tension; the stretch removable pressure sensitive adhesive layer includes a pressure sensitive adhesive matrix and a fibrous reinforcing material within the pressure sensitive adhesive matrix; and the adhesive layer has a yield strength and a tensile strength, and wherein the tensile strength is about 0.7 MPa or greater, and at least about 150% of the yield
10 strength.

Yet another method of removing a medical article that delaminates involves: providing a medical article adhered to skin, wherein the medical article includes a backing and a stretch removable pressure sensitive adhesive layer disposed thereon; and stretching the medical article in a direction relative
15 to the skin to which it is adhered sufficient to delaminate the adhesive layer from the backing and remove the article from the skin. In this embodiment: the backing and the adhesive layer are selected such that the stretchability of the adhesive layer is greater than that of the backing under the same tension; the stretch removable pressure sensitive adhesive layer includes a pressure sensitive
20 adhesive matrix that includes a polymer derived from at least one alkyl ester monomer selected from isooctyl acrylate, 2-ethyl-hexyl acrylate, and n-butyl acrylate, and at least one co-monomer selected from acrylic acid and acrylamide; and a fibrous reinforcing material within the pressure sensitive adhesive matrix; and the adhesive layer has a yield strength and a tensile strength, and wherein the
25 tensile strength is about 0.7 MPa or greater, and at least about 150% of the yield strength.

Preferably, a medical article that delaminates upon removal is provided and includes a backing and a stretch removable pressure sensitive adhesive layer disposed thereon. The backing and the adhesive layer are selected such that the
30 stretchability of the adhesive layer is greater than that of the backing under the same tension and the adhesive layer and backing delaminate when removed from

skin. Preferably, for enhanced delamination, the adhesive layer and backing form separate phases (i.e., are in separate layers).

For the articles that delaminate upon removal, the adhesive layer can include a wide variety of polymers, such as a poly(meth)acrylate (e.g., a polymer
5 derived from at least one alkyl ester monomer selected from isooctyl acrylate, 2-ethyl-hexyl acrylate, and n-butyl acrylate, and at least one co-monomer selected from acrylic acid and acrylamide) or an A-B-A block copolymer. It can be reinforced as with a fibrous reinforcing material. Preferably, the adhesive layer includes: a pressure sensitive adhesive matrix; and a fibrous reinforcing material
10 within the pressure sensitive adhesive matrix; wherein the adhesive layer has a yield strength and a tensile strength, and wherein the tensile strength is about 0.7 MPa or greater, and at least about 150% of the yield strength.

The present invention also provides a method of making a medical article that delaminates upon removal as described above. The method includes
15 providing a backing; selecting a stretch removable pressure sensitive adhesive such that the stretchability of the adhesive layer disposed on the backing is greater than that of the backing under the same tension; and laminating the backing and the pressure sensitive adhesive layer together under conditions of temperature and pressure that allow the adhesive layer and backing to delaminate
20 when removed from skin.

With respect to another general embodiment, the present invention also provides methods of removal, methods of making, and articles that include a predefined tab on the backing. Specifically, the present invention provides a stretch removable adhesive article that includes a backing with a predefined tab
25 and a pressure sensitive adhesive layer disposed on a major surface of the backing opposite that of the tab, wherein the predefined tab is located in a central portion of the backing. Preferably, the pressure sensitive adhesive is a stretch removable pressure sensitive adhesive. More preferably, the backing and the adhesive layer are selected such that the stretchability of the adhesive layer is
30 greater than that of the backing under the same tension, more preferably, at least about 10% greater.

For the articles that include a predefined tab, the adhesive layer can include a wide variety of polymers, such as a poly(meth)acrylate (e.g., a polymer derived from at least one alkyl ester monomer selected from isooctyl acrylate, 2-ethyl-hexyl acrylate, and n-butyl acrylate, and at least one co-monomer selected from acrylic acid and acrylamide) or an A-B-A block copolymer. It can be reinforced as with a fibrous reinforcing material. Preferably, the adhesive layer includes: a pressure sensitive adhesive matrix; and a fibrous reinforcing material within the pressure sensitive adhesive matrix; wherein the adhesive layer has a yield strength and a tensile strength, and wherein the tensile strength is about 0.7 MPa or greater, and at least about 150% of the yield strength.

The tab can be in a wide variety of shapes, sizes, and made of a wide variety of materials. In one preferred embodiment, the tab includes a portion of the backing and a portion of the adhesive layer. In another preferred embodiment, the backing includes two pieces (optionally overlapping pieces), preferably each with a nonadhesive end (i.e., an end free of exposed adhesive) that forms a tab.

In a preferred embodiment of the article with a predefined tab, the present invention provides a stretch removable adhesive article that includes a backing with a predefined tab and a stretch removable pressure sensitive adhesive layer disposed thereon, wherein the predefined tab is located in a central portion of the backing, and further wherein the backing and the adhesive layer are selected such that the stretchability of the adhesive layer is greater than that of the backing under the same tension. Preferably, the adhesive layer includes: a pressure sensitive adhesive matrix; and a fibrous reinforcing material within the pressure sensitive adhesive matrix; wherein the adhesive layer has a yield strength and a tensile strength, and wherein the tensile strength is about 0.7 MPa or greater, and at least about 150% of the yield strength.

The present invention also provides a method of removing an article having a predefined tab from a surface. The method involves: providing a stretch removable adhesive article adhered to a surface, wherein the article includes a backing with a predefined tab and a pressure sensitive adhesive layer disposed thereon, wherein the predefined tab is located in a central portion of the

backing; and pulling on the tab to stretch the adhesive article in an amount sufficient to remove the article from the surface. Preferably, the pressure sensitive adhesive is a stretch removable pressure sensitive adhesive. More preferably, the backing and adhesive are selected such that the stretchability of the adhesive layer is greater than that of the backing under the same tension.

There is also provided a method of making a medical article that involves: providing a backing with a predefined tab located in a central portion of the backing; and applying a stretch removable pressure sensitive adhesive to a major surface of the backing opposite that of the predefined tab. The step of applying can involve laminating, spray coating, etc.

In this application, the following terms are defined as follows, unless otherwise stated:

“Delamination” or “delaminate” means that, upon stretching an adhesive article, the adhesive separates (i.e., detaches) from at least a portion of the backing.

“Elastic” means how well a stretched material will recover. An elastic material is one that will recover by at least about 50% after being stretched in at least one direction, preferably by at least about 60%, more preferably by at least about 75%, and most preferably by at least about 100% after being stretched (i.e., it returns to its original size). An inelastic or nonelastic material is one that will recover by less than about 50% after being stretched.

“Stretchability” means how far a material can be elongated. A stretchable material is one that does not break upon elongating the material by at least about 20% in at least one direction. Unless otherwise stated, stretchability is assumed to be for elongation of a material in the lengthwise direction. A nonstretchable material is one that breaks upon stretching the material by less than about 20%. Percent stretchability (or elongation) at a given tension/force or at break can be measured by inspection of the plots generated via ASTM D3759 (1996) or D5459 (1995).

“Stretch removable” means that a pressure sensitive adhesive or article, when pulled and elongated (preferably from a substrate surface at a rate of 30

centimeters/minute and at an angle of no greater than 45°) detaches from a substrate surface without significant damage to the substrate surface (e.g., tearing), and without leaving a significant residue, preferably that which is visible to the unaided human eye on the substrate.

- 5 “Substantially continuous” means that for an at least 0.5 centimeter length sample of the adhesive composition taken in the machine direction, at least 50% of the fibers present in the sample are continuous (i.e., unbroken).

 “Tensile strength” is the maximum tensile strength at break when tested according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30
10 centimeters/minute).

Brief Description of the Drawings

FIG. 1 is an enlarged side view in cross-section of an adhesive tape of the present invention that includes a backing, optionally perforated, in the
15 unstretched position.

FIG. 2 is an enlarged side view in cross-section of an adhesive tape with the adhesive having been stretched and beginning to be removed from the substrate and delaminate from the backing.

FIG. 3 is an enlarged side view in cross-section of a first aid dressing of the present invention that includes a perforated backing with perforations near the gauze pad with the backing having been broken and the adhesive having been stretched and beginning to cease holding to both the substrate and the backing.
20

FIGS. 4-11 are representations of embodiments of the adhesive articles of the present invention having various types of tabs.

25 FIG. 12 is a plan view of one medical article according to the present invention with tapered terminal portions.

FIG. 13 is a plan view of another medical article according to the present invention with two pairs of opposing tapered terminal portions.

FIG. 14 is a plan view of another medical article according to the present
30 invention with two pairs of opposing tapered terminal portions.

FIG. 15 is a plan view of another medical article according to the present invention with two pairs of opposing tapered terminal portions.

FIG. 16 is a plan view of another medical article according to the present invention including multiple pairs of opposing tapered terminal portions.

5 FIG. 17 is a view of one tapered terminal portions useful in connection with articles according to the present invention.

Detailed Description of Preferred Embodiments

10 The present invention provides stretch removable adhesive articles, particularly adhesive articles that include a backing having a stretch removable pressure sensitive adhesive layer disposed on at least one major surface thereof. Preferably, the adhesive articles are designed for use on skin or other delicate surfaces with no significant damage to the skin or other delicate surface, and if the surface is skin, there is little or no pain upon removal of the adhesive article.

15 Other stretch removable adhesive articles, pressure sensitive adhesives for use in such articles and backings for use in such articles are described in, e.g., U.S. Patent Application Serial No. 09/764,540, filed January 17, 2001 and titled STRETCH REMOVABLE ADHESIVE ARTICLES AND METHODS; U.S. Patent Application Serial No. 09/764,478, filed January 17, 2001 and titled
20 PRESSURE SENSITIVE ADHESIVES AND A FIBROUS REINFORCING MATERIAL; and U.S. Patent Application Serial No. 09/847,942, filed herewith and titled PRESSURE SENSITIVE ADHESIVES WITH A REINFORCING MATERIAL.

25 Preferably, such adhesive articles are tapes that include gauze pads, for example, and are used as first aid dressings (i.e., wound or surgical dressings). The adhesive articles can be in the form of a wide variety of other medical articles, such as medical tapes, athletic tapes, surgical drapes, or tapes or tabs used in adhering medical devices such as sensors, electrodes (as disclosed in U.S. Pat. No. 5,215,087 (Anderson et al.), and U.S. Pat. No. 6,171,985 (Joseph et
30 al.), for example), ostomy appliances, or the like. Adhesive articles of the present invention can also be in the form of removable labels, coupons, masking tapes, tapes or tabs used in adhering diapers, packaging, food storage containers,

etc. They can be used in tamper-indicating applications, particularly if upon stretching, the adhesive articles do not recover their original shape. Preferred embodiments, however, are medical articles.

5 Generally, adhesive articles (e.g., tapes) of the present invention may be designed to be removed from a surface with or without concomitant delamination of the adhesive layer from the backing or by using a predefined tab located in a central portion of the backing (preferably, over a gauze pad). These designs provide significant advancements, particularly in the area of medical articles because of the ability to remove an adhesive article (e.g., bandage, tape) without significant pain, irritation, or injury to the underlying skin.

10 If delamination during removal is desired, the backing and adhesive are preferably selected such that the stretchability of the adhesive is greater than that of the backing. Preferably, the stretchability at break of the adhesive is at least about 10% greater than that of the backing. Generally, with conventional stretch removable adhesive articles the backing and the stretch removable adhesive are selected such that they stretch together for effective release; however, with adhesive articles of the present invention, delamination of the adhesive from the backing allows for a mismatch in stretch.

20 Selection of an adhesive and a backing for those embodiments in which delamination is desired involves evaluating each of their respective stretchabilities as well as their bonding capacity for each other and for the surface to which they are adhered. That is, the adhesive and backing are selected such that they have sufficient adhesion to each other and do not separate from each other prior to removal of the adhesive article from a surface to which it is adhered. Stretchability can be determined by measuring the elongation of a material or construction when pulled by a known force up to and including the point at break, such as by using an INSTRON machine according to ASTM D3759 (1996) or D5459 (1995). Preferably, the stretchability at break of the adhesive (layer) is at least about 100%, more preferably, at least about 300%, and most preferably, at least about 400%. Preferably, the stretchability at break of the adhesive is no greater than about 800%.

Preferred adhesive articles of the present invention have an initial adhesion to a surface, such as skin for medical articles, of at least about 20 grams per 2.5 centimeters (0.8 Newtons per decimeter), and more preferably, at least about 40 grams per 2.5 centimeters (1.6 N/dm). This can be evaluated, for example, using PSTC-1 Peel Adhesion Test, a testing protocol established by the Specifications and Technical Committee of the Pressure-sensitive Tape Council located at 5700 Old Orchard Road, Skokie, IL.

Effective adhesion between the backing and adhesive can be determined by ASTM D1876 (1995). Preferred adhesives and backings of the present invention have an initial adhesion to each other of at least about 10 grams per 2.5 centimeters (0.4 Newtons per decimeter), and more preferably, at least about 20 grams per 2.5 centimeters (0.8 N/dm). This adhesion can be affected not only by the choice of materials but also by the lamination and/or coating process. For example, conditions of lamination and/or coating involve those wherein the adhesive layer and backing maintain separate layers (i.e., phases). That is, neither melting of the adhesive or backing occurs during the laminating process to form a separate continuous layer at the interface, nor does the adhesive deform and flow into the backing, as in a nonwoven web backing, for example.

Delamination means that, upon stretching an adhesive article, the adhesive separates (i.e., detaches) from at least a portion of the backing. Preferably, the adhesive separates from at least about 50% of the area of the backing, more preferably, the adhesive separates from at least about 60%, even more preferably, at least about 80%, and most preferably, at least about 95%, of the area of the backing, wherein the area of the backing is determined after the article is stretched and removed from a surface. Typically to accomplish delamination, the internal (i.e., structural) strength of the adhesive is greater than the adhesion of the adhesive to the backing. Delamination can be enhanced, for example, by laminating under low pressure and/or low temperature, eliminating pretreatment methods (e.g., corona treatment) typically used in preparing adhesive articles, by using a low adhesion backsize between the backing and the backing and a stiff adhesive, etc.

Preferably, for effective delamination upon removal of an adhesive article from a surface, the lamination temperature during the manufacturing process of the adhesive article does not exceed the softening temperature of either the backing material or any reinforcing materials in the adhesive layer.

- 5 Laminating above the softening temperature but below the melting temperature is typically not sufficient, since diffusion and adhesion can build up significantly above the softening temperature. For example, many ethylene vinyl acetate materials have melting temperatures about 60°C to about 90°C with softening temperatures about 40°C to about 75°C.

- 10 Generally, delamination occurs upon stretching an adhesive article lengthwise in a direction substantially parallel to the plane of the surface to which it is adhered (prior to pulling), although this is not a necessary requirement to accomplish delamination (i.e., delamination can occur upon pulling and stretching the article in a direction from about 0° to about 90° from
- 15 the surface to which it is attached). A simple test to determine if the backing and adhesive have sufficiently different stretchability to allow for delamination is to place a piece of the adhesive construction (1 centimeter by 4 centimeters) on a desired surface, for example, skin, a mirror-finished steel panel, or a polypropylene substrate, by rubbing down with light thumb pressure, optionally
- 20 allowing for the adhesion to the substrate surface to build over a short period of time (e.g., about 10 minutes), and then pulling and stretching at a desired rate (for example, 30 or 152 centimeters per minute) at a desired angle (preferably at an angle no greater than about 45° from the plane of the adhesive bond, and more preferably lengthwise in a direction substantially parallel to the plane of the
- 25 adhesive bond). The construction is then visually examined to determine if at least a portion of the area of the backing (after stretching) has been separated from the adhesive during removal. Because the backing can be stretched without recovery, the area of the backing used to make this evaluation is that after the stretch removal process.

- 30 In certain adhesive articles of the present invention, and independent of whether or not delamination occurs upon stretch removal, the backing includes a

predefined tab located in a central portion of the backing (i.e., the about 80% of the mid portion of the backing along its length). Such adhesive articles having tabs can be used in a wide variety of applications, as discussed above. Typically, the adhesive article is removed by grasping and pulling the tab in a direction that is substantially normal to the plane of the surface to which the article is adhered (prior to pulling), although this is not a necessary requirement for effective functioning of the tab (i.e., removal can occur upon pulling the tab in a direction from about 0° to about 90° from the surface to which it is attached). With a tab (i.e., handle) in a central portion of a backing, the adhesive article typically does not get scraped over the wound as it is being removed as often can occur when it is pulled from an end across the wound. Preferably, by placing the tab in a central portion of the backing, the force of elongation can be distributed over two portions of the adhesive article (i.e., the two portions on either side of the tab).

15 **Pressure Sensitive Adhesive**

A wide variety of pressure sensitive adhesives can be used for this invention as long as they are stretch removable or are part of an adhesive article (i.e., adhesive construction) that is stretch removable. Preferably, the adhesive itself is stretch removable as defined above. Preferably, the stretch removable pressure sensitive adhesive is one that is suitable for use on skin, for example, acrylate polymers, natural and synthetic rubbers, silicone polymers, polyurethanes, polyolefins, and poly(vinyl ethers), as generally described in the article "Medical Adhesives: Adhesive Considerations for Developing Stick-to-Skin Products," Adhesives Age, October, 2000.

25 The pressure sensitive adhesive can be any material that has pressure sensitive adhesive properties. One well known means of identifying pressure sensitive adhesives is the Dahlquist criterion. This criterion defines a pressure sensitive adhesive as an adhesive having a 1 second creep compliance of greater than 1×10^{-6} cm²/dyne as described in Handbook of Pressure Sensitive Adhesive Technology, Donatas Satas (Ed.), 2nd Edition, p. 172, Van Nostrand Reinhold, New York, NY, 1989. Alternatively, since modulus is, to a first approximation,

the inverse of creep compliance, pressure sensitive adhesives may be defined as adhesives having a Young's modulus of less than 1×10^6 dynes/cm². Another well known means of identifying a pressure sensitive adhesive is that it is aggressively and permanently tacky at room temperature and firmly adheres to a variety of dissimilar surfaces upon mere contact without the need of more than finger or hand pressure, and which may be removed from smooth surfaces without leaving a residue as described in Test Methods for Pressure Sensitive Adhesive Tapes, Pressure Sensitive Tape Council, (1996). Another suitable definition of a suitable pressure sensitive adhesive is that it preferably has a room temperature storage modulus within the area defined by the following points as plotted on a graph of modulus versus frequency at 25°C: a range of moduli from approximately 2×10^5 to 4×10^5 dynes/cm² at a frequency of approximately 0.1 radian/second (0.017 Hz), and a range of moduli from approximately 2×10^6 to 8×10^6 dynes/cm² at a frequency of approximately 100 radians/second (17 Hz) (for example see FIG. 8-16 on p. 173 of Handbook of Pressure Sensitive Adhesive Technology, Donatas Satas (Ed.), 2nd Edition, Van Nostrand Reinhold, New York, 1989). Any of these methods of identifying a pressure sensitive adhesive may be used to identify suitable pressure sensitive adhesives for use in the methods of the present invention.

Furthermore, the pressure sensitive adhesive layer of the adhesive articles of the present invention can be a single pressure sensitive adhesive or it can be a combination of two or more pressure sensitive adhesives. Suitable adhesives are inherently stretchy, as in styrene block copolymers, or they can be reinforced to increase cohesive strength and stretchability.

The adhesive articles of the present invention include a continuous layer or a discontinuous layer (e.g., porous layer) of a stretch removable pressure sensitive adhesive. This may result from solvent coating, screen printing, roller printing, melt spraying, stripe coating, or laminating processes, for example. Porosity can also occur by perforating a continuous adhesive layer. An adhesive layer can have a wide variety of thicknesses so long as it possesses pressure sensitive adhesive characteristics, and preferably, stretch removable pressure

sensitive adhesive characteristics, with thicknesses preferably ranging from about 10 micrometers (i.e., microns) to about 1000 micrometers.

The pressure sensitive adhesive can be in the form of fibers intimately entangled each with the other in the form of a coherent breathable fibrous nonwoven adhesive web. Suitable nonwoven webs can be formed as melt blown microfiber webs using the apparatus discussed, for example, in Wentz, Van A., "Superfine Thermoplastic Fibers," Industrial Engineering Chemistry, Vol. 48, pages 1342-1346, Wentz, Van A. et al., "Manufacture of Superfine Organic Fibers," Report No. 4364 of the Naval Research Laboratories, published May 25, 1954, and in U.S. Pat Nos. 3,849,241 (Butin et al.), 3,825,379 (Lohkamp et al.), and others. These microfine fibers are termed melt blown fibers or blown microfibers (BMF) and are generally substantially continuous and form into a coherent web between the exit die orifice and a collecting surface by entanglement of the microfibers due in part to the turbulent airstream in which the fibers are entrained. Other conventional melt spinning type processes, such as spunbond processes where the fibers are collected in a web form immediately upon fiber formation, can also be used to form the adhesive layer. Generally, the fibers are 100 microns or less in diameter when formed by melt spinning type processes, preferably 50 microns or less. The fibers, if formed by the melt blown process, can be produced as described in U.S. Pat. Nos. 5,176,952 (Joseph et al.); 5,232,770 (Joseph); 5,238,733 (Joseph et al.); 5,258,220 (Joseph); or 5,248,455 (Joseph et al.). The fibers can also be produced by a spunbond process as are disclosed in U.S. Pat. Nos. 5,695,868 (McCormach); 5,336,552 (Strack et al.); 5,545,464 (Stokes); 5,382,400; 5,512,358 (Shawyer et al.); or 5,498,463 (McDowall et al.).

Pressure sensitive adhesives useful in the present invention include, for example, those based on natural rubbers, synthetic rubbers, styrene block copolymers, polyvinyl ethers, poly(meth)acrylates (including both polyacrylates and polymethacrylates), polyolefins, and silicones. The pressure sensitive adhesive may be inherently tacky. If desired, tackifiers may be added to a base material to form the pressure sensitive adhesive. Useful tackifiers include, for example, rosin ester resins, aromatic hydrocarbon resins, aliphatic hydrocarbon

resins, and terpene resins. Other materials can be added for special purposes, including, for example, oils, plasticizers, antioxidants, ultraviolet ("UV") stabilizers, hydrogenated butyl rubber, pigments, and curing agents.

Suitable stretchable block copolymers would include those formed using a tackified elastomer where a preferred elastomer is an A-B-A type block copolymer wherein the A blocks and B blocks are configured in linear, radial, or star configurations. The A block is formed of a mono-alkenylarene (preferably polystyrene) block having a molecular weight of about 4000 to about 50,000. The A block content is preferably about 10 weight percent to about 50 weight percent. Other suitable A blocks may be formed from alpha-methylstyrene, t-butyl-styrene and other ring-alkylated styrenes, as well as mixtures thereof. The B block is formed of an elastomeric conjugated diene, generally polyisoprene, polybutadiene or copolymers thereof having an average molecular weight from about 5000 to about 500,000. The B block dienes can also be hydrogenated. The B block content is preferably about 90 percent to about 50 percent of the block copolymer. The tackifying components for the stretchable block copolymers generally are solid tackifying resins, liquid tackifiers, plasticizers, or mixtures thereof. Suitable liquid tackifiers or plasticizers for use in the adhesive polymer include naphthenic oils, paraffin oils, aromatic oils, mineral oils or low molecular weight rosin esters, polyterpenes, and C-5 resins.

In a preferred embodiment, the pressure sensitive adhesive is based on poly(meth)acrylates (e.g., a polymethacrylic or polyacrylic pressure sensitive adhesive). Poly(meth)acrylic pressure sensitive adhesives are derived from, for example, at least one alkyl ester monomer such as, for example, isooctyl acrylate, isononyl acrylate, 2-methyl-butyl acrylate, 2-ethyl-hexyl acrylate, and n-butyl acrylate; and an optional co-monomer component such as, for example, (meth)acrylic acid, vinyl acetate, N-vinyl pyrrolidone, (meth)acrylate, (meth)acrylamide, a vinyl ester, a fumarate, a styrene macromer, or combinations thereof. Preferably, the poly(meth)acrylic pressure sensitive adhesive is derived from about 0 to about 20 weight percent of acrylic acid and about 100 weight percent to about 80 weight percent of at least one of isooctyl acrylate, 2-ethyl-hexyl acrylate or n-butyl acrylate composition, preferably

isooctyl acrylate. A particularly preferred embodiment for the present invention is derived from about 2 weight percent to about 10 weight percent acrylic acid, about 90 weight percent to about 98 weight percent of isooctyl acrylate, and about 2 weight percent to about 6 weight percent styrene macromer.

5 The poly(meth)acrylate pressure sensitive adhesives can be synthesized by a variety of free-radical polymerization processes, including solution, radiation, bulk, dispersion, emulsion, and suspension polymerization processes. Bulk polymerization methods, such as the continuous free radical polymerization method described in U.S. Pat. Nos. 4,619,979 (Kotnor et al.) or 4,843,134
10 (Kotnor et al.), the essentially adiabatic polymerization methods using a batch reactor described in U.S. Pat. No. 5,637,646 (Ellis), and the methods described for polymerizing packaged pre-adhesive compositions described in International Patent Application No. WO 96/07522 (Hamer et al.) may also be utilized.

15 The poly(meth)acrylate pressure sensitive adhesive of the present invention can include conventional additives such as tackifiers (wood rosin, polyesters, etc.), plasticizers, flow modifiers, neutralizing agents, stabilizers, antioxidants, fillers, colorants, and the like. Initiators that are not copolymerizable with the monomers used to prepare the (meth)acrylate copolymer can also be used to enhance the rate of polymerization and/or
20 crosslinking. These additives are incorporated in amounts that do not materially adversely affect the desired properties of the pressure sensitive adhesives. Typically, they can be mixed into these systems in amounts of about 0.05 weight percent to about 25 weight percent, based on the total weight of the composition.

25

Pressure Sensitive Adhesive Reinforcing Material

 In a preferred embodiment, the pressure sensitive adhesive is reinforced to increase the internal strength of the adhesive, and hence, its stretchability. This can be accomplished through the use of chemical or physical crosslinking,
30 the addition of a second polymeric component having a higher glass transition temperature, or the addition of nonpolymeric fillers (e.g., calcium carbonate, clay, zinc oxide) or the addition of fibers into the pressure sensitive adhesive.

Suitable reinforced adhesives are disclosed in International Publication Nos. WO 97/23577 (Hyde et al.) and WO 96/25469 (Hyde et al.), U.S. Pat. No. 6,045,895 (Hyde et al.), and in U.S. Patent Application Serial No. 09/764,478, entitled "Pressure Sensitive Adhesives and a Fibrous Reinforcing Material," filed on January 17, 2001.

Preferably, the reinforced pressure sensitive adhesive has a yield strength of no less than about 0.1 MPa when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute). In specific embodiments, the yield strength is no less than about 0.2 MPa when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute). Additionally, the reinforced pressure sensitive adhesive (i.e., reinforced pressure sensitive adhesive composition) has a tensile strength of at least about 150% of the yield strength when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute).

In certain embodiments of the preferred reinforced pressure sensitive adhesive, the tensile strength is about 0.7 MPa or greater when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute). In specific embodiments of the preferred reinforced pressure sensitive adhesive, the tensile strength is about 0.8 MPa or greater when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute). The adhesive composition may have a tensile strength of at least about two times greater than the tensile strength of the pressure sensitive adhesive alone when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute).

For preferred embodiments, the elongation at break for the reinforced pressure sensitive adhesive composition is at least about 50% when measured according to ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute), preferably more than about 200%, and may be higher than about 300%. In some embodiments the elongation at break is in excess of about 800%.

Additionally, in preferred embodiments, the amount of force required to remove the adhesive composition from a polypropylene substrate at an angle of

between 15° and 35°, is less than about 20 Newtons/decimeter. This low removal force permits facile removal of the adhesive composition from a substrate. In certain embodiments, the force necessary to remove the adhesive composition from a substrate at such an angle is as low as about 7

5 Newtons/decimeter.

Various reinforcing materials may be used in the pressure sensitive adhesive. In preferred embodiments, the reinforcing material is a polymer. In specific embodiments, the reinforcing material is elastomeric. Preferably, the reinforcing material is a semi-crystalline polymer. A semi-crystalline polymer
10 is one having both amorphous and crystalline domains. Many specific embodiments incorporate semi-crystalline polymers, such as polycaprolactone (PCL), polybutene (PB), copolymers derived from ethylene and at least one other alpha-olefin monomer (e.g., poly(ethylene-co-1-alkene) and poly(ethylene-co-1-alkene-co-1-alkene)), ultra low density polyethylene (e.g.,
15 ATTANE 4202 commercially available from Dow Chemical Co.), linear low density polyethylene (e.g., LL-3003, ECD-125, 377D60, 369G09, 363C32, 361C33, 357C32, 350D65, 350D64, 350D60, LL-3013, and LL-3001 commercially available from Exxon Mobil Corp.) or combinations thereof.

Preferred reinforcing materials have a yield strength of less than about 20
20 MPa. The tensile strength of the reinforcing material with respect to its yield strength is preferably about 150% of the yield strength. These values are measured using ASTM D 882-97 at a crosshead speed of 12 inches/minute (30 centimeters/minute).

The reinforcing material preferably has a melting point above the use
25 temperature of the adhesive composition. Similarly, the reinforcing material should have a melting point above the storage temperature of the adhesive composition or any article manufactured with the adhesive composition. Both the use temperature and the storage temperature should not exceed the decomposition temperature of the pressure sensitive adhesive. In certain
30 embodiments, the reinforcing material has a melting point of at least 70°C. All temperatures are related as being measurable by differential scanning calorimetry ("DSC").

It is particularly desirable for the reinforcing material to have a melt viscosity similar to the melt viscosity of the pressure sensitive adhesive at the processing temperature of the method of this invention. In specific embodiments, the ratio of the reinforcing material melt viscosity to the pressure sensitive adhesive melt viscosity at the processing temperature is less than about 3, preferably less than about 1.5. In preferred embodiments, the ratio is between about 0.5 and about 1.2 depending on specific extrusion parameters (e.g. shear rate, screw speed, temperature). Melt viscosity is measurable as understood by one skilled in the art using a capillary viscometer.

The reinforcing material is preferably immiscible (i.e., remains in a separate phase) in the pressure sensitive adhesive during mixing so that the reinforcing material can be substantially uniformly dispersed (i.e., distributed) in the pressure sensitive adhesive. In specific embodiments, during mixing, the reinforcing material is in the form of substantially spherical particles having an average diameter less than about 20 micrometers, generally less than about 10 micrometers.

In preferred embodiments, the reinforcing material exists as substantially continuous fibers in the adhesive composition. Specifically, according to one aspect of the invention, the fibers are unbroken for at least about 0.5 centimeter in the machine direction of the pressure sensitive adhesive matrix, preferably about 2 to about 5 centimeters and more preferably about 8 centimeters. According to another aspect of the invention, the substantially continuous fibers generally have a maximum diameter of about 0.05 micrometer to about 5 micrometers, preferably from about 0.1 micrometer to about 1 micrometer. According to another aspect of the invention, the aspect ratio (i.e. the ratio of the length to the diameter) of the substantially continuous fibers is greater than about 1000.

Examples of such reinforced pressure sensitive adhesives are further described in U.S. Patent Application Serial No. 09/764,478, entitled "Pressure Sensitive Adhesives and a Fibrous Reinforcing Material," filed on January 17, 2001.

Backing

A wide variety of materials can be used to form the backing. The backing can be tearable or nontearable, elastic or inelastic, stretchable or nonstretchable, porous or nonporous. Backings can be in the form of single or multi-layer films, nonwoven films, porous films, foam-like films, and combinations of the foregoing. Backings can also be prepared from filled materials, such as, for example, filled films (e.g., calcium carbonate filled polyolefins).

Film backings can be made by any known method of film forming, such as, for example, extrusion, coextrusion, solvent casting, foaming, nonwoven technology, and the like. A backing can have a wide variety of thicknesses so long as it possesses sufficient integrity to be processable and, preferably, capable of forming tabs or having tabs attached thereto, with thicknesses preferably ranging from about 10 micrometers (i.e., microns) to about 250 micrometers.

Webs made from natural or synthetic fibers or mixtures thereof can be used. Woven or nonwoven materials can be employed, with nonwoven materials being preferred for most applications. Melt-blown or spunbond techniques can be employed to make such nonwoven webs. Nonwoven webs can also be prepared on a Rando Webber (Rando Corporation, Macedon, NY) air-laying machine or on a carding machine.

If the backing substrate is in the form of a laminate, additional components could be used, such as absorbent layers (e.g., gauze pads) for adhesive bandage products, or the like. If absorbent layers are used, they are typically thin, coherent, conformable, and able to flex and not interfere with the stretch removable characteristics of the articles, although they can be stretchable or not.

If a laminate, there may be one or more additional layers, which can be a breathable, liquid impervious film. Typically this film is the outermost (i.e., top) layer. Examples of film materials include polyurethanes, polyolefins, metallocene polyolefins, polyesters, polyamides, polyetheresters, and A-B-A block copolymers, such as KRATON copolymers available from Shell Chemical Co. Preferably, the outermost layer is a film that is substantially impervious to fluids, such as could arise from the external environment, yet permit passage of

moisture vapor, such that the adhesive article is breathable (typically, having a moisture vapor transmission rate (MVTR) of at least about 500 g/m²/day).

The backing can optionally include fibers, which may be absorbent or nonabsorbent, and typically they are non-water absorptive. The fiber structures
5 useful in the backing substrate of the present invention can include a multilayer configuration, a coated configuration, and a solid homogeneous configuration. Suitable multilayer fibers preferably have cores and outer layers composed of one or more polymers selected from polyolefins, polyesters, polyamides, and polyurethanes. Suitable coated fibers preferably have cores made of these
10 polymers with coatings covalently bonded, embedded, or adhered thereto. The homogeneous fibers preferably are made of any of the polymers listed above. Such fibers can be formed into backings using known weaving, knitting, or nonwoven techniques. Suitable such backings are disclosed, for example, in U.S. Pat. No. 5,613,942 (Lucast et al.).

15 In a preferred embodiment, the backing is formed from coherent multicomponent fibers having at least one pressure sensitive adhesive region or layer and at least one non-pressure sensitive adhesive region or layer as described in U.S. Pat. No. 6,107,219 (Joseph et al.). In another preferred embodiment, the backing is a melt blown polypropylene web available from
20 Kimberly Clark, Irving, TX.

Typically, fibers forming a nonwoven tape backing are intimately entangled each with the other in the form of a coherent breathable fibrous nonwoven tape backing. Suitable nonwoven tape backings can be formed as melt blown microfiber webs using the apparatus discussed, for example, in
25 Wentz, Van A., "Superfine Thermoplastic Fibers," Industrial Engineering Chemistry, Vol. 48, pages 1342-1346, Wentz, Van A. et al., "Manufacture of Superfine Organic Fibers," Report No. 4364 of the Naval Research Laboratories, published May 25, 1954, and in U.S. Pat Nos. 3,849,241 (Butin et al.), 3,825,379 (Lohkamp), and others. These microfine fibers are termed melt blown fibers or
30 blown microfibers (BMF) and are generally substantially continuous and form into a coherent web between the exit die orifice and a collecting surface by entanglement of the microfibers due in part to the turbulent airstream in which

the fibers are entrained. Other conventional melt spinning type processes, such as spunbond processes where the fibers are collected in a web form immediately upon fiber formation, can also be used to form the invention nonwoven tape backing. Generally, the fibers are 100 microns or less in diameter when formed by melt spinning type processes, preferably 50 microns or less. The multicomponent fibers, if formed by the melt blown process, can be produced as described in U.S. Pat. Nos. 5,176,952 (Joseph et al.); 5,232,770 (Joseph); 5,238,733 (Joseph et al.); 5,258,220 (Joseph); or 5,248,455 (Joseph et al.). The multicomponent fiber can also be produced by a spunbond process as are disclosed in U.S. Pat. Nos. 5,695,868 (McCormach); 5,336,552 (Strack et al.); 5,545,464 (Stokes); 5,382,400; 5,512,358 (Shawyer et al.); or 5,498,463 (McDowall et al.).

In preferred embodiments of the present invention in which a stretch removable adhesive article can be prepared without a stretch removable adhesive, the backing is an elastic nonwoven web, as disclosed in U.S. Pat. No. 5,629,079 (Battles et al.). These elastic nonwoven webs include blown microfibers formed by extrusion of thermoplastic elastomers through a die, which produces fine, randomly oriented fibers. Several different constructions of webs are suitable for use in this embodiment of the invention. In multilayered blown microfibers, the elastic nonwoven web includes longitudinally layered melt-blown microfibers with layers of a low modulus or elastomeric materials and adjacent layers of heat bondable materials. In commingled blown microfibers, the elastic nonwoven web includes at least two different types of melt-blown microfibers. A first microfiber includes a low modulus or elastomeric material; a second microfiber includes a heat bondable material. In blown microfiber web having intertangled staple fiber, an elastomeric nonwoven web is produced using an elastomeric blown microfiber and a larger-diameter staple fibers. The elastomeric microfibers and staple fibers of the resulting web are generally randomly intermixed and intertangled. All three embodiments can be used in stretch removable articles of the present invention, particularly in embodiments in which the adhesive is not necessarily stretch removable.

Representative examples of materials suitable for the backing of the adhesive article of this invention include polyolefins, such as polyethylene, including high density polyethylene, low density polyethylene, linear low density polyethylene, and linear ultra low density polyethylene, polypropylene, and polybutylenes; vinyl copolymers, such as polyvinyl chlorides, both plasticized and unplasticized, and polyvinyl acetates; olefinic copolymers, such as ethylene/methacrylate copolymers, ethylene/vinyl acetate copolymers, acrylonitrile-butadiene-styrene copolymers, and ethylene/propylene copolymers; acrylic polymers and copolymers; polycaprolactones; and combinations of the foregoing. Mixtures or blends of any plastic or plastic and elastomeric materials such as polypropylene/polyethylene, polyurethane/polyolefin, polyurethane/polycarbonate, polyurethane/polyester, can also be used.

Additionally, any nonstretchable material can be used for the tearable backings or for those with perforations, including paper and even metal. Preferred materials for the backing include polyurethane, polypropylene, ethylene vinyl acetate, or combinations thereof (e.g., blends, mixtures, etc.) in the form of melt blown fibers. Preferred materials for film backings include polycaprolactones and copolymers of ethylene/vinyl acetate and linear low density polyethylene.

The backing can have perforations or holes to provide porosity or for assisting in removing the adhesive articles or in delamination. These perforations may be in a variety of shapes (e.g., circular, rectangular, oval) and sizes and positioned in various predetermined locations depending on the desired break points upon removal of the adhesive article. For example, perforations can be located in the backing near a centrally located gauze pad so that pulling on the gauze pad causes the backing to break, and the pad/backing/adhesive act as a tab to remove the remainder of the article by stretching. Such perforations can be made using well known techniques. They can be partially or completely occluded, closed, or masked until stretching of the article. The perforations are typically of a size that does not allow the adhesive to extend through and impart tackiness to the opposite surface on which the adhesive is disposed. Preferably, the perforations are at least about 0.0025 centimeter (cm) in diameter, more preferably, at least about 0.01 cm, and most preferably, at least about 0.02 cm in

diameter. Preferably, the perforations are not greater than about 0.04 cm in diameter.

Referring to FIGS. 1-3, an adhesive construction (e.g., tape) 10 of this invention includes a backing 14 bearing on at least one major surface thereof a pressure sensitive adhesive layer 12, which is preferably stretch removable. As shown in FIG. 1, tape 10 is adhered to substrate 16 and includes an optional gauze pad 18, for example, in the form of a wound dressing. As shown in FIG. 1, the backing is optionally perforated along lines 19. If desired, in this and other embodiments described herein the adhesive and/or backing over the pad 18 need not necessarily be stretchy. Also, the gauze pad may or may not be stretchy.

As shown in FIG. 2, during removal, the tape 10 is stretched substantially parallel to the substrate 16 surface and the adhesive layer 12 elongates and stretch releases from the substrate 16 and delaminates from at least part of the backing 14. If the adhesive construction includes perforations 19 in the backing 14, the perforated backing can tear (i.e., break) (not shown in FIG. 2).

As shown in FIG. 3, if the backing 14 possesses perforations (previously located at the points of break 20 in the backing 14) near the pad 18, the backing 14 can break at both sides of the pad 18 on stretching the construction (for simplicity, delamination of the adhesive 12 from the backing 14 is not shown except at the break points 20) by applying a pulling force along the direction of line F on the region of the tape 10 that encompasses the pad 18, which could also include a tab as discussed in greater detail below. An alternative embodiment of such a construction would not necessarily have perforations but could be removed in a similar fashion, i.e., by grasping the central portion of the backing 14 and pulling to stretch the article.

An image, if desired, can be placed on the adhesive portion of the construction and will be made visible on breaking the backing and stretching (not shown).

Tabs

The backings of the present invention may be equipped with tabs or handles in the form of grip ledges, folds, loops, and other devices to facilitate removal of the adhesive article (e.g., tape or wound dressing). The use of such tabs may be advantageous in obviating the need for prying (using a finger nail, for example) the end or center of an adhesive article from a surface prior to removal. Preferably, such tabs are located in a central portion of the backing (i.e., the center 80% of the length of a backing), and more preferably over the pad area if it is present.

The tabs can be in a variety of shapes and sizes. They can be made of a thin, highly flexible film that does not snag on environmental objects. The tabs may also be made by securing a ribbon of thin film or a thread under a bar of adhesive applied across the width of the backing. The tabs may also be formed from other parts of the backing, such as simply by making a fold in the backing during manufacture, which can be done before or after application of the adhesive. If the tab is formed after the adhesive is applied to the backing, the tab can include a portion of the adhesive. Alternatively, the backing can be in the form of two pieces, optionally with overlapping ends, each of which have a nonadhesive portion, i.e., a portion free of exposed adhesive. These ends can be free of adhesive or have a piece of liner covering the adhesive at the ends.

The preferred centrally located tabs are particularly advantageous for the removal of a wound dressing as they can reduce the pain of removal and allow careful avoidance of damage to the wounded area during removal. Such tabs are preferably grasped and pulled at about 45° up to right angles (i.e., normal) to the substrate and surface to which the adhesive article is attached, although this angle may be reduced to near zero (i.e., substantially in the plane of the adhesive bond) if the surface is not rigid (e.g., skin). Accordingly, a gauze pad of a wound dressing, for example, can clear the delicate central area of the wound first and typically can be prevented from scraping over the wound. Furthermore, the gentle pressures that result from releasing the dressing act to hold the wound shut. Advantageously, the tearing effect on the wound of customary dressing

removal is typically avoided. The articles and methods of removal that utilize tabs are advantageous in that they prevent digging under one end of the adhesive tape "wings" of a wound dressing and peeling from one end to the other. Pain typically results from digging out hair or skin with the fingernails, from tearing out hair stuck to the dressing adhesive during the peeling operation, and from tearing at the edges of the wound.

Desirably, unpleasant and possibly septic or virus-containing wound exudate can be contained and concealed from view by the pinching action of removal that results in the dressing ending up folded in half widthwise and adhered together with the exudate inside. This removal action can be done with one hand. The method is quick, clean, gentle, and generally painless, and thus especially suited for children and the elderly.

The tab (i.e., handle) is preferably designed such that snagging or picking does not remove the adhesive article prematurely, for example, and that it indicates which direction to pull to get the benefit of the invention. Preferably, the tab is secured permanently in one area and temporarily in one or more other areas or is made *in situ* from other parts of the dressing during manufacture. The temporary securement of part of the tab is to prevent snagging and hooking. The tab may be colored to show where it is, and it may be printed with an arrow showing which way to pull it to get the painless removal benefit. Further directions could be on the wrapper or the box containing the medical articles.

Depending on the application, the tabs of the adhesive articles can be placed at different locations for advantageous removal. For example, in one preferred embodiment, a medical article is designed for adhesion to relatively loose skin, such as on the top of the forearm. In this embodiment, the point of attachment of the tab is generally symmetrically straddling the center gauze pad and centered in the long dimension of the dressing. In another preferred embodiment a medical article is designed for adhesion to skin that is relatively taut, as on the palm of the hand. In this embodiment, the point of attachment of the tab is preferably centered across the width of the pad, but located off center relative to the length of the article (although still within the central portion of the adhesive article).

Referring to FIGS. 4-9, various preferred embodiments of a wound dressing (e.g., approximately 1.9 cm by 7.6 cm) are shown that include a backing (e.g., PGI 6012 Comfort Silk Film from Polymer Group, Inc., Gainesville, GA), an adhesive layer (e.g., Adhesive A described in the Examples Section), and
5 central gauze pad material (e.g., approximately 1.3 cm by 2.5 cm of a pad of an 108 gram/square meter absorbent rayon nonwoven laminated on both sides with P530S DELNET commercially available from Applied Extrusion Technologies, Middletown, DE). Each embodiment demonstrates a different tab construction.

Referring to FIG. 4, the backing 40 of a preferred wound dressing is
10 shown with a gauze pad 42 positioned on the opposite side of the backing 40 (shown by the hatched lines) and a tab 44. The tab 44 could be a string, thread, or polymer ribbon film (e.g., mercerized sewing thread) fixed to the backing 40 on the surface opposite the pad 42 with a bead of adhesive 46 (e.g., epoxy), preferably reaching from one side of the backing to the other across the narrow
15 dimension (i.e., the width). The thread-shaped tab 44 is shown attached at the center along the length of the backing 40. Alternatively, it can be attached off center along the length of the backing 40, if desired.

Referring to FIG. 5, the tab 54 could be made of thin polyester or other film shaped like a "T" and fixed across the width of the backing 50 with
20 adhesive under or incorporating the top of the "T." The T shown in Fig. 5 is made of 0.5-mil (12.5-micron) polyester film and has a distance across portion 55 (or crossbar) of the T of 13 mm and the widths of the arms are 2 mm each. The portion 55 of the T is approximately centered on the long dimension of the pad and is adhered to the backing 50 with an adhesive (e.g., an adhesive
25 commercially available from 3M Company, St. Paul, MN, under the trade designation SUPER STRENGTH ADHESIVE) to form a permanent bond. Alternatively, the portion 55 of the T could be attached off center along the length of the backing 50, if desired. The portion 56 of the T is variable in length, but is preferably at least about 7 mm for ease of grasping, and is temporarily
30 anchored to the backing 50 with an adhesive (e.g., an adhesive commercially available from 3M Company under the trade designation SCOTCH RESTICKABLE ADHESIVE glue stick) to form a nonpermanent bond.

Referring to FIG. 6, the tab 64 is a half loop (rectangular or rounded) of material (e.g., thread) the open ends of which are fixed to the backing 60 midway along its length such that the resulting loop straddles an underlying gauze pad 62 symmetrically. Alternatively, the half loop-shaped tab 64 can be attached off center along the length of the backing 60, if desired. In this embodiment, the material of the tab 64 is thread and can be permanently adhered to the backing between the gauze pad 62 and the backing 60 (e.g., using 3M SUPER STRENGTH ADHESIVE) in a manner such that the thread would not touch the wound (as shown by hatched line 63). The half loop-shaped tab 64 can be temporarily adhered to the backing 60 (e.g., using SCOTCH RESTICKABLE ADHESIVE glue stick) until the adhesive article is to be removed. Passing these loop-shaped tabs between the pad and the backing could help distribute the load when fragile backings and adhesives are used. They could be completely impregnated with adhesive when used in this way to avoid wicking wound exudate out from under the dressing.

Referring to FIG. 7, the tab 74 is a rectangular or rounded half loop of material (e.g., 0.5-mil (12.5-micron) polyester film) the open ends of which are fixed to the backing 70 across its width so that the resulting loop straddles the underlying gauze pad 72, but is located at one end of the pad 72. The ends 73 (shaded) of the tab 74 are permanently adhered to the backing 70 (e.g., using 3M SUPER STRENGTH ADHESIVE) and the remainder can be temporarily adhered to the backing 70 (e.g., using SCOTCH RESTICKABLE ADHESIVE glue stick) until the adhesive article is to be removed.

Referring to FIG. 8, the tab 84 is a rectangular shaped film (e.g., 0.5-mil (12.5-micron) polyester film) surrounding the underlying gauze pad 82. The tab 84 is permanently adhered along one edge 83 (shaded edge) (e.g., using 3M SUPER STRENGTH ADHESIVE) so one part of the rectangular-shaped tab 84 sticks to the backing while the other part lifts up. The tab could be a part of the backing cut to form a half moon shaped tab, for example, and easily picked up with a fingernail.

Referring to FIG. 9, a tab 94 is shown in cross-section that is formed from the backing 90, as can be done by making a fold in the backing during

manufacture, either before or after application of the adhesive. In this embodiment the fold was made after the adhesive 98 was applied, thereby resulting in adhesive within the tab 94.

FIG. 9A is a perspective view of one alternative tab construction in which a folded tab 94' is formed by creating two fold lines 93' and 95' in the backing 90'. The depicted tab 94' may be formed after locating the adhesive 98' on the backing 90' as depicted in FIG. 9A. The folded tab 94' may preferably be secured to the remainder of the backing 90 proximate the outer fold line 95' to hold the tab 94' down until removal is desired. It may be preferred that the tab 94' be secured to the backing 90' along a line of attachment 96' across the width of the backing 90' proximate the outer fold line 95'. In addition, the tab 94' may also be secured to the backing 90' proximate the base fold line 93' along a line of attachment 92'.

Although the lines of attachment are referred to as "lines," it will be understood that they may be provided as discrete points of attachment located along the lines described herein. In yet another alternative, discrete points of attachment may be dispersed over substantially all of the tab 94'. In still another alternative, substantially the entire tab 94' may be secured to the backing 90. In all cases, however, it may be preferred to provide a small portion of the tab 94' proximate the outer fold line 95' that is not secured to the backing to facilitate release of the tab 94' for grasping when removal is desired.

The lines of attachment may be provided in a variety of forms. As depicted the line of attachment 92' proximate the base fold line 93' and the line of attachment 96' proximate the outer fold line 95' may be provided in the form of a plurality of ultrasonically-formed perforations. Many alternatives to the use of a plurality of ultrasonically-formed perforations will be recognized by those skilled in the art, including, but not limited to, adhesives, ultrasonic welding, perforations, chemical welding, etc.

The line of attachment proximate the outer fold line 95' is preferably spaced from the outer fold line 95' towards the base fold line 93' by a sufficient distance to allow for release of the tab 94' when desired, yet not so far from the outer fold line 95' that the tab 94' is subjected to excessive unwanted release

during normal activities. For example, it may be desired that about 1 millimeter (mm) of the tab 94' be allowed to extend past the line of attachment 96'.

The line of attachment 92' proximate the base fold line 93' is preferably located either on the base fold line 93' or just inside of the base fold line 93' towards the outer fold line 95'. This location for the line of attachment 92' may enhance formation of the base fold line 93' as well as assisting in securing the tab 94' to the backing 90'.

FIG. 9B depicts another mode of securing a tab 94" to a backing 90" in connection with articles according to the present invention. In the depicted embodiment (illustrated in a plan view), the tab 94" may be secured along the edges of the backing by a lines of attachment 92" and 96" located on opposite edges of the tab 94". If desired, an additional line of attachment may be provided along the base of the tab 94" (similar to the line of attachment 92' described above with respect to FIG. 9A). This mode of securing the tab 94" may desirably provide a pocket formed by the backing 90" and tab 94" that may be used to release the tab 94".

FIGS. 10 and 11 show two wound dressing constructions made from a tape construction as described in Example 1C in the Examples Section, the central pad 106 material being an 108 gram/square meter absorbent rayon nonwoven laminated on both sides with P530S DELNET commercially available from Applied Extrusion Technologies, Middletown, DE. Tabs 102 and 103 are 3 mm wide oriented polypropylene film commercially available as PROPORE KN9400 film from 3M Company, St. Paul, MN.

In FIGS. 10 and 11 the backing can be in the form of two adhesive-coated pieces 100 and 101 with ends that have a nonadhesive portion in the form of tabs 102 and 103 that can overlap each other over the gauze pad 106 (as shown in FIG. 10) or not (as shown in FIG. 11). Each end forms a tab 102 and 103 for the respective backing piece 100 and 101. Referring to the embodiment shown in FIG. 10, for example, to remove the article, tab 102 is first pulled outward (i.e., away from tab 103) at an angle of about 10° allowing the adhesive to release from backing piece 101 over the pad 106, while backing piece 100 is removed from the skin. After removal of backing piece 100, the pad 106 can be

folded under to form a handle for removal of backing piece 101 by stretching in a direction toward the area of removed backing piece 100. Alternatively, tab 103 can be grasped instead of folding the pad 106.

5 These descriptions of tab forms are not intended to be complete as other tab constructions could be used to pull up in the central position of the adhesive article.

For certain of the preferred wound dressings described above, it is useful to use a stretchable gauze pad. A stretchable gauze pad stays adhered to the deformable tape construction better than a non-stretchy pad, and the stretch
10 removal behavior is communicated from one adhesive wing of the dressing to the other when a stretchy pad is used. This is especially true when an island pad occupying a large fraction of the width of the dressing is used.

Absorbent Particles and Other Additives

15 Wet skin adhesion characteristics of the adhesive articles of the present invention can be provided by an absorbent particulate material, typically in the form of a powder or larger particles, including fibers, herein referred to generally as particulate material or particles. The particles can be of any desired shape, such as round, flake-like, elongated, or irregular, for example. The particulate
20 matter can be distributed uniformly throughout the backing substrate or can be coated onto either major surface of the backing. A sufficient amount of absorbent particulate material is present in or on the backing substrate to provide the desired levels of wet skin adhesion.

The particulate material is sufficiently water absorptive to provide
25 articles having sufficient wet skin adhesion, preferably, at least about 20 g/2.5 cm (0.08 N/cm). Preferably, the particulate material is superabsorbent. Suitable superabsorbent particles are made from polymers that are capable of absorbing at least about 50 times their weight of water. Suitable superabsorbent particulate material can be prepared from carboxymethylcellulose and its sodium and
30 potassium salts, hydroxymethylcellulose, hydroxyethylcellulose, poly(acrylamide), poly(acrylic acid) and its sodium and potassium salts, alginates, and starch-graft copolymers such as those of acrylates and acrylamides

and their salts. Examples of such materials are disclosed in U.S. Pat. No. 5,064,653 (Sessions et al.). Although superabsorbent particles are preferred, other absorbent particles can be used if desired, such as gelatins, polysaccharides, gums including pectin, guar gum, xantham gum, and karaya gum.

Examples of other additives that can be included into the backing and/or adhesive include odor absorbers such as activated carbon, medicaments such as chlorhexidine gluconate, biologically active agents, cosmetic agents, and the like, which can be in particulate form or incorporated into encapsulating agents.

The adhesive and/or backing can also include dye-based or pigment-based inks in the form of an image (e.g., text or picture). Preferably, the adhesive layer includes an image that becomes visible upon removal and delamination. The image can be applied using a wide variety of conventional techniques, such as ink jet printing, electrophotography, screen printing, etc.

Tapered Constructions

As discussed in the summary, it may be advantageous to taper portions of the backing and adhesive to control the release properties of the article to a surface, e.g., skin. Various illustrative embodiments of stretch removable adhesive articles are described below that include tapered terminal portions, although it should be understood that the present invention is not to be limited to the specific examples described below.

FIG. 12 depicts one illustrative embodiment of a stretch removable adhesive article, preferably a stretch removable medical adhesive article. The article 200 includes a backing having a central portion 210 and a pair of opposing terminal portions 220a and 220b (for convenience, the terminal portions 220a and 220b will be commonly referred to as terminal portions 220 unless otherwise specified). The article 200 may optionally include a pad 212 located within the central portion 210 as described above.

The opposing terminal portions 220 are each tapered towards a tip 226. The terminal portions 220 include two opposing edges 222 and 224 that lead to the tip 226. The opposing edges 222 and 224 may preferably be straight as

depicted in FIG. 12. Alternatively, the edges 222 and 224 may be curved or otherwise not formed as straight lines. For example, the edges 222 and 224 may be convex, concave, or some other shape.

Regardless of the exact shape of the opposing edges 222 and 224, they
5 will generally form an included angle α (alpha) as depicted in FIG. 12. For example, if the opposing edges 222 and 224 are curved, the included angle may be measured along tangent lines to the edges 222 and 224. It may be preferred that the included angle α (alpha) be about 90 degrees or less to provide a desired rate of taper within the terminal portion 220. At the other end of the range, it
10 may be preferred that the included angle α (alpha) be about 30 degrees or more to provide sufficient surface area within the terminal portion to assist with maintaining adhesion of the terminal portion 220 to a desired surface.

In the article 200, the terminal portions 220 are connected directly to the central portion 210 of the backing. The width of the central portion 210 and,
15 thus, the maximum width of the terminal portions 220, may be adjusted to obtain the desired release characteristics. In such an arrangement, it may be preferred that the width of the central portion 210 (measured perpendicular to the longitudinal axis 221) be about 30 millimeters (mm) or less at the junction of the central portion and the terminal portion 220. It may alternatively be preferred
20 that the width of the central portion 210 at that junction be about 25 mm or less. At the other end of the range, it may be preferred that the width of the central portion 210 be about 10 millimeters (mm) or more at the junction of the central portion and the terminal portion 220. It may alternatively be preferred that the width of the central portion 210 at that junction be about 15 mm or more.

25 Referring to, e.g., FIGS. 9, 9A, and 9B, any folded tabs provided in connection with the medical article 200 are preferably provided with fold lines that are not aligned with the longitudinal axis 221 within the central portion 210 of the article 200. Fold axis 293 is depicted in FIG. 12 as one example of a fold line axis for a base fold line that is generally perpendicular to the longitudinal
30 axis 221 of the article 200.

FIG. 13 depicts another alternative embodiment of a stretch removable adhesive article according to the present invention. The stretch removable

adhesive article 300 includes a central portion 310 that, in the depicted embodiment, includes an optional pad 312. The pad 312 is provided in the shape of an octagon, although the pad 312 may have any shape suitable for use with stretch removable adhesive article 300. The article 300 includes two pairs of
5 opposing terminal portions 320a, 320b, 320c, 320d (for convenience, all of the terminal portions will be referred to as terminal portions 320 unless otherwise specified).

The terminal portions 320 all extend outwardly from the central portion 310 of stretch removable adhesive article 300. Referring to terminal portion
10 320a, each of the terminal portions 320 is connected to the central portion 310 of the stretch removable adhesive article 300 by a leg 330 that, in the depicted embodiment, includes two substantially parallel sides 332 and 334. The terminal portions 320a and 320c oppose each other along a common axis 321 that extends through the tips of each of the opposing terminal portions. Similarly, terminal
15 portions 320b and 320d oppose each other along a common axis 323 that extends through the tips of each of the opposing terminal portions.

The two common axes 321 and 323 intersect with each other within the central portion 310 of the stretch removable adhesive article 300. At their intersection, the common axes 321 and 323 may be substantially perpendicular
20 to each other when only two pairs of opposing terminal portions are provided in connection with the stretch removable adhesive article 300.

In other embodiments, the common axes may not be perpendicular. For example, it may be preferred that the common axes 321 and 323 form two pairs of equal vertical angles. In such a situation, it may be preferred that the smaller
25 pair of vertical angles be about 45 degrees or more.

Unlike article 200 of FIG. 12, the terminal portions 320 are connected to the central portion 310 of the backing by legs 330. As a result, the width of the legs 330 and, thus, the maximum width of the terminal portions 320, may be adjusted to obtain the desired release characteristics. In such an arrangement, it
30 may be preferred that the width of the legs 330 (measured perpendicular to the common axes) be about 30 millimeters (mm) or less at the junction of the leg 330 and the terminal portion 320. It may alternatively be preferred that the

width of the leg 330 at that junction be about 25 mm or less. At the other end of the range, it may be preferred that the width of the leg 330 be about 10 millimeters (mm) or more at the junction of the leg 330 and the terminal portion 330. It may alternatively be preferred that the width of the leg 330 at that
5 junction be about 15 mm or more. These dimensions for the widths of the legs and terminal portions may also be applied to other embodiments of the invention, e.g., those described below in connection with FIGS. 14-17.

Referring to, e.g., FIGS. 9, 9A, and 9B, any folded tabs provided in connection with the medical article 300 are preferably provided with fold lines
10 that are not aligned with either of the common axes 321 and 323. It may further be preferred that the base fold line of any such tab intersect the common axes 321 and 323 at their point of intersection as depicted in FIG. 13. Further, it may be preferred that in a medical article 300 including two pairs of opposing terminal portions 320, that the base fold line generally bisect one pair of vertical
15 angles formed by the intersection of the common axes 321 and 323. Fold axis 393 is depicted in FIG. 13 as one example of a fold line axis for a base fold line that does intersect the common axes 321 and 323 at their point of intersection and that does generally bisect one pair of vertical angles formed by the intersection of the common axes 321 and 323.

20 FIG. 14 depicts another alternative embodiment of a stretch removable adhesive article 400 according to the present invention. The stretch removable adhesive article 400 includes a central portion 410 within optional pad 412. The stretch removable adhesive article 400 also includes two pairs of opposing terminal portions 420a, 420b, 420c, 420d ((for convenience, all of the terminal
25 portions will be referred to as terminal portions 420 unless otherwise specified).

The terminal portions 420 all extend outwardly from the central portion 410 of stretch removable adhesive article 400. Referring to terminal portion 420a, each of the terminal portions 420 is connected to the central portion 410 of the stretch removable adhesive article 400 by a leg 430 that, in the depicted
30 embodiment, includes two substantially parallel sides 432 and 434.

The terminal portions 420a and 420d oppose each other along a common axis 421 that extends through the tips of each of the opposing terminal portions.

Similarly, terminal portions 420b and 320c oppose each other along a common axis 423 that extends through the tips of each of the opposing terminal portions. Unlike the common axes depicted in FIG. 13, common axes 421 and 423 do not intersect with the central portion 410 of the stretch removable adhesive article 400. Rather, the common axes 421 and 423 are aligned with each other. It may be preferred that common axes 421 and 423 are parallel, but that orientation is not required.

Referring to, e.g., FIGS. 9, 9A, and 9B, any folded tabs provided in connection with the medical article 400 are preferably provided with fold lines that are not aligned with any of the common axes 421 and 423 extending through the opposing pairs of terminal portions 420. It may further be preferred that the base fold line of any such tab be generally perpendicular to the common axes 421 and 423. Fold axis 493 is depicted in FIG. 14 as one example of a fold line axis for a base fold line that is generally perpendicular to the common axes 421 and 423 of the article 400.

FIG. 15 depicts another alternative embodiment of a stretch removable adhesive article 500 according to the present invention. The stretch removable adhesive article 500 includes a central portion 510 with an optional pad 512. The stretch removable adhesive article 500 also includes two pairs of opposing terminal portions 520a, 520b, 520c, 520d. One variation between stretch removable adhesive article 400 and stretch removable adhesive article 500 is that the central portion of article 500 includes arcuate or curved sides.

FIG. 16 depicts another alternative embodiment of a stretch removable adhesive article 600 according to the present invention. The stretch removable adhesive article 600 includes a central portion 610 with an optional pad 612. The stretch removable adhesive article 600 also includes multiple pairs of opposing terminal portions 620 located on opposite sides of the central portion 610. Removal of this embodiment may be accomplished along the length of the article 600 by successively stretching opposing pairs of the terminal portions 620. Although the opposing pairs of terminal portions 620 are depicted as arranged directly across the central portion 610, it will be understood that the pairs of opposing terminal portions may be offset across the central portion 610.

Referring to, e.g., FIGS. 9, 9A, and 9B, any folded tabs provided in connection with the medical article 600 are preferably provided with fold lines that are not aligned with any of the common axes extending through the opposing pairs of terminal portions 620. It may further be preferred that the base
5 fold line of any such tab be generally perpendicular to the common axes of the opposing pairs of terminal portions 620.

FIG. 17 illustrates one terminal portion 720 and associated leg 730 used to attach the terminal portion 720 to the central portion of a stretch removable adhesive article (not shown). The terminal portion 720 includes a tip 726 and
10 two edges 722 and 724 leading to the tip 726. As seen in FIG. 17, the tip 726 may preferably be radiused to resist unwanted detachment from a surface.

Also depicted in FIG. 17 is a longitudinal axis 721 extending through the tip 726. At the other end, the longitudinal axis extends through the central portion of the stretch removable adhesive article (see, e.g., FIGS. 2 and 3). It
15 may be preferred, but is not required, that the longitudinal axis bisect the included angle formed between the edges 722 and 724 as depicted in FIG. 17.

As discussed above, the edges 722 and 724 may be straight as depicted in FIG. 17, but other profiles may alternatively be used, e.g., convex curves, concave curves, a plurality of straight and/or curved segments, etc. The exact
20 profile of the edges 722 and 724 is unimportant provided they converge towards the tip 726 to provide the desired release characteristics as described above.

One manner in which the tapering nature of the terminal portion 720 may be characterized may rely on the width of the terminal portion at various places along the longitudinal axis 721. Unless otherwise specified, all widths are
25 measured perpendicular to the longitudinal axis 721. The terminal portion 720 has a maximum width w_m at its junction with the leg 730, which has a leg width w_l . As seen in FIG. 17, the leg width and the maximum width of the terminal portion may be equal, but are not necessarily equal.

Also seen in FIG. 17 is a setback width w_s measured at a setback distance
30 d_s along the longitudinal axis 721. The setback width and the maximum width of the terminal portion 720 can be used to characterize the taper of the terminal portion. For example, it may be preferred that the setback distance be about 5

millimeters (mm). With the setback distance at that value, it may be preferred that the setback width (w_s) be about 10 mm or less, alternatively about 8 mm or less. At the lower end of the range, it may be preferred that the setback width be about 2.5 mm or more, alternatively about 6 mm or more.

- 5 In another characterization of the tapering nature of the terminal portion 720, it may be preferred that the setback distance be based on the maximum width of the terminal portion 720, such that, e.g., the setback distance (d_s) is about 25% of the maximum width (w_m) of the terminal portion 720. With the setback distance at that value, it may be preferred that the setback width (w_s) be
- 10 about 60% or less of the maximum width of the terminal portion 720, alternatively about 45% or less of the maximum width of the terminal portion 720. At the lower end of the range, it may be preferred that the setback width be about 10% or more of the maximum width of the terminal portion 720, alternatively about 30% or more of the maximum width of the terminal portion
- 15 720.

- The complete disclosures of the patents, patent documents, and publications cited herein are incorporated by reference in their entirety as if each
- 20 were individually incorporated. Various modifications and alterations to this invention will become apparent to those skilled in the art without departing from the scope and spirit of this invention. It should be understood that this invention is not intended to be unduly limited by the illustrative embodiments and examples set forth herein and that such examples and embodiments are presented
- 25 by way of example only with the scope of the invention intended to be limited only by the claims set forth herein as follows.

What is claimed is:

1. A medical article comprising:
a backing comprising a plurality of terminal portions extending
5 outwardly from a central portion, wherein each terminal portion of the plurality
of terminal portions tapers towards a tip located distal from the central portion,
wherein each terminal portion of the plurality of terminal portions comprises two
edges leading to the tip, the two edges defining an included angle of about 90
degrees or less; and
10 a stretch removable pressure sensitive adhesive layer disposed on the
backing.
2. The medical article of claim 1, wherein the included angle defined by the
two edges of each terminal portion of the plurality of terminal portions is about
15 30 degrees or more.
3. The medical article of claim 1, wherein the two edges of each terminal
portion of the plurality of terminal portions comprise two straight edges.
- 20 4. The medical article of claim 1, wherein the tip of each terminal portion of
the plurality of terminal portions comprises a radiused tip.
5. The medical article of claim 1, wherein each terminal portion of the
plurality of terminal portions is connected to the central portion by a leg.
25
6. The medical article of claim 5, wherein the leg comprises a leg width that
is equal to a maximum width of the terminal portion.
7. The medical article of claim 5, wherein each terminal portion of the
30 plurality of terminal portions comprises a maximum width located at a junction
between the terminal portion and the leg

8. The medical article of claim 1, wherein the plurality of terminal portions comprises only one pair of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair opposing terminal portions.

9. The medical article of claim 1, wherein the plurality of terminal portions comprises two or more pairs of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions, and further wherein the common axes of two or more pairs of opposing terminal portions are aligned with each other.

10. The medical article of claim 1, wherein the plurality of terminal portions comprises only two pairs of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions, and further wherein the common axes of the two pairs of opposing terminal portions are intersect each other within the central portion of the backing.

11. The medical article of claim 10, wherein the common axes are substantially perpendicular.

12. The medical article of claim 1, further comprising a predefined tab located within the central portion of the backing.

13. The medical article of claim 1, further comprising a predefined tab located within the central portion of the backing, wherein the predefined tab comprises a fold in the backing.

14. The medical article of claim 1, further comprising a predefined tab located within the central portion of the backing, wherein the predefined tab comprises a fold in the backing, the fold comprising a portion of the stretch removable pressure sensitive adhesive layer.

5

15. The medical article of claim 1, further comprising a predefined tab located within the central portion of the backing, wherein the predefined tab comprises a fold in the backing, and further wherein the fold is secured to the backing.

10

16. The medical article of claim 1, wherein the plurality of terminal portions comprises only one pair of opposing terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions;

15

and wherein the medical article further comprises a predefined tab located within the central portion of the backing, wherein the predefined tab comprises a fold in the backing, the fold defining a fold axis that intersects the common axis of the pair of opposing terminal portions.

20

17. The medical article of claim 16, wherein the fold axis is perpendicular to the common axis.

25

18. The medical article of claim 1, wherein the plurality of terminal portions comprises two or more pairs of opposing terminal portions, each pair of opposing terminal portions comprising two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions;

30

and wherein the medical article further comprises a predefined tab located within the central portion of the backing, wherein the predefined tab comprises a fold in the backing, the fold defining a fold axis that intersects the common axis of each pair of the two or more pairs of opposing terminal portions.

19. The medical article of claim 1, wherein the stretchability at break of the stretch removable adhesive layer is at least about 300%.

5

20. The medical article of claim 1, wherein the stretchability at break of the stretch removable adhesive layer is no greater than about 800%.

21. A medical article comprising:

10 a backing comprising a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions tapers towards a tip located distal from the central portion, wherein each terminal portion of the plurality of terminal portions comprises two edges leading to the tip, the two edges defining an included angle of about 90
15 degrees or less, and further wherein the included angle defined by the two edges is about 30 degrees or more;

a stretch removable pressure sensitive adhesive layer disposed on the backing; and

a predefined tab located within the central portion of the backing,
20 wherein the predefined tab comprises a fold in the backing, and further wherein the fold is secured to the backing;

wherein the plurality of terminal portions comprises one or more pairs of opposing terminal portions, each pair of opposing terminal portions comprising two terminal portions located on opposite sides of the central portion and aligned
25 along a common axis extending through the tips of the pair of opposing terminal portions.

22. A medical article comprising:

a backing comprising a plurality of terminal portions extending
30 outwardly from a central portion;

a stretch removable pressure sensitive adhesive layer disposed on the backing; and

wherein each terminal portion of the plurality of terminal portions comprises a longitudinal axis, a tip located distal from the central portion of the backing along the longitudinal axis, a maximum width measured perpendicular to the longitudinal axis;

5 wherein each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions comprises a setback width measured at a setback distance of 5 millimeters towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 10 millimeters or less when measured
10 perpendicular to the longitudinal axis, and further wherein the setback width is about 2.5 millimeters or more when measured perpendicular to the longitudinal axis.

23. The medical article of claim 22, wherein the setback width is about 6
15 millimeters or more when measured perpendicular to the longitudinal axis, and further wherein the setback width is about 8 millimeters or less when measured perpendicular to the longitudinal axis.

24. The medical article of claim 22, wherein each terminal portion of the
20 plurality of terminal portions is connected to the central portion of the backing by a leg, and further wherein the maximum width of each terminal portion of the plurality of terminal portions is located at a junction between the terminal portion and the leg.

25 25. The medical article of claim 22, wherein each terminal portion of the plurality of terminal portions comprises two straight edges leading to the tip.

26. The medical article of claim 22, wherein the tip of each terminal portion of the plurality of terminal portions comprises a radiused tip.

30 27. The medical article of claim 22, wherein the plurality of terminal portions comprises only one pair of opposing terminal portions, wherein the pair of

opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions.

5 28. The medical article of claim 22, wherein the plurality of terminal portions comprises two or more pairs of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions, and further wherein the
10 common axes of two or more pairs of opposing terminal portions are aligned with each other.

29. The medical article of claim 22, wherein the plurality of terminal portions comprises two pairs of opposing terminal portions, wherein each pair of
15 opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the opposing terminal portions, and further wherein the common axes of the two pairs of opposing terminal portions are intersect each other within the central portion of the backing.

20

30. The medical article of claim 29, wherein the common axes are substantially perpendicular.

31. A medical article comprising:
25 a backing comprising at least first and second terminal portions extending outwardly from a central portion;
a stretch removable pressure sensitive adhesive layer disposed on the backing; and
wherein each terminal portion of the plurality of terminal portions
30 comprises a longitudinal axis, a tip located distal from the central portion of the backing along the longitudinal axis, a maximum width measured perpendicular to the longitudinal axis;

wherein each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions comprises a setback width measured at a setback distance that is 25% of the maximum width towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 60% or less of the maximum width when measured perpendicular to the longitudinal axis, and further wherein the setback width is about 10% or more of the maximum width when measured perpendicular to the longitudinal axis.

32. The medical article of claim 31, wherein the setback width is about 30% or more of the maximum width when measured perpendicular to the longitudinal axis, and further wherein the setback width is about 45% or less of the maximum width when measured perpendicular to the longitudinal axis.

33. The medical article of claim 31, wherein each terminal portion of the plurality of terminal portions is connected to the central portion of the backing by a leg, and further wherein the maximum width of each terminal portion of the plurality of terminal portions is located at a junction between the terminal portion and the leg.

34. The medical article of claim 31, wherein each terminal portion of the plurality of terminal portions comprises two straight edges leading to the tip.

35. The medical article of claim 31, wherein the tip of each terminal portion of the plurality of terminal portions comprises a radiused tip.

36. The medical article of claim 31, wherein the plurality of terminal portions comprises only one pair of opposing terminal portions, wherein the pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions.

37. The medical article of claim 31, wherein the plurality of terminal portions comprises two or more pairs of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the pair of opposing terminal portions, and further wherein the common axes of two or more pairs of opposing terminal portions are aligned with each other.

38. The medical article of claim 31, wherein the plurality of terminal portions comprises two pairs of opposing terminal portions, wherein each pair of opposing terminal portions comprises two terminal portions located on opposite sides of the central portion and aligned along a common axis extending through the tips of the opposing terminal portions, and further wherein the common axes of the two pairs of opposing terminal portions intersect each other within the central portion of the backing.

39. The medical article of claim 38, wherein the common axes are substantially perpendicular.

40. A method of removing a medical article from skin, the method comprising:

providing a medical article adhered to skin, wherein the medical article comprises:

a backing comprising a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions tapers towards a tip located distal from the central portion, wherein each terminal portion of the plurality of terminal portions comprises two edges leading to the tip, the two edges defining an included angle of about 90 degrees or less; and

a stretch removable pressure sensitive adhesive layer disposed on the backing; and

grasping the medical article within the central portion; and
stretching the medical article from the central portion to remove the
medical article from the skin.

5 41. The method of claim 40, wherein the medical article further comprises a
predefined tab located within the central portion of the backing, and further
wherein grasping the medical article comprises grasping the predefined tab; and
still further wherein stretching the medical adhesive article further comprises
pulling on the predefined tab to stretch the medical article in an amount
10 sufficient to remove the medical article.

42. The method of claim 40, wherein the predefined tab comprises a fold in
the backing, the predefined tab comprising a base fold line and an outer fold line,
and further wherein predefined tab is secured to the backing proximate the outer
15 fold line, and still further wherein the method further comprises releasing the
outer fold line from the backing before pulling on the predefined tab.

43. A method of removing a medical article from skin, the method
comprising:
20 providing a medical article adhered to skin, the medical article
comprising:

25 a backing comprising a plurality of terminal portions extending
outwardly from a central portion;

30 a stretch removable pressure sensitive adhesive layer disposed on
the backing; and

35 wherein each terminal portion of the plurality of terminal portions
comprises a longitudinal axis, a tip located distal from the central
portion of the backing along the longitudinal axis, a maximum width
measured perpendicular to the longitudinal axis;

40 wherein each terminal portion of the plurality of terminal portions
tapers towards the tip such that each terminal portion of the plurality
of terminal portions comprises a setback width measured at a setback

distance of 5 millimeters towards the central portion from the tip
along the longitudinal axis, wherein the setback width is about 10
millimeters or less when measured perpendicular to the longitudinal
axis, and further wherein the setback width is about 2.5 millimeters or
5 more when measured perpendicular to the longitudinal axis; and
grasping the medical article within the central portion; and
stretching the medical article from the central portion to remove the
medical article from the skin.

10 44. The method of claim 43, wherein the medical article further comprises a
predefined tab located within the central portion of the backing, and further
wherein grasping the medical article comprises grasping the predefined tab; and
still further wherein stretching the medical adhesive article further comprises
pulling on the predefined tab to stretch the medical article in an amount
15 sufficient to remove the medical article.

45. The method of claim 43, wherein the predefined tab comprises a fold in
the backing, the predefined tab comprising a base fold line and an outer fold line,
and further wherein predefined tab is secured to the backing proximate the outer
20 fold line, and still further wherein the method further comprises releasing the
outer fold line from the backing before pulling on the predefined tab.

46. A method of removing a medical article from skin, the method
comprising:

25 providing a medical article adhered to skin, the medical article
comprising:

a backing comprising at least first and second terminal portions
extending outwardly from a central portion;

30 a stretch removable pressure sensitive adhesive layer disposed on
the backing; and

wherein each terminal portion of the plurality of terminal portions
comprises a longitudinal axis, a tip located distal from the central

portion of the backing along the longitudinal axis, a maximum width measured perpendicular to the longitudinal axis;

5 wherein each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions comprises a setback width measured at a setback distance that is 25% of the maximum width towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 60% or less of the maximum width when measured perpendicular to the longitudinal axis, and further wherein the setback
10 width is about 10% or more of the maximum width when measured perpendicular to the longitudinal axis; and

grasping the medical article within the central portion; and stretching the medical article from the central portion to remove the medical article from the skin.

15

47. The method of claim 46, wherein the medical article further comprises a predefined tab located within the central portion of the backing, and further wherein grasping the medical article comprises grasping the predefined tab; and still further wherein stretching the medical adhesive article further comprises
20 pulling on the predefined tab to stretch the medical article in an amount sufficient to remove the medical article.

48. The method of claim 46, wherein the predefined tab comprises a fold in the backing, the predefined tab comprising a base fold line and an outer fold line,
25 and further wherein predefined tab is secured to the backing proximate the outer fold line, and still further wherein the method further comprises releasing the outer fold line from the backing before pulling on the predefined tab.

49. A method of making a medical article, the method comprising:
30 providing a backing;
applying a stretch removable pressure sensitive adhesive to a major surface of the backing;

converting the backing and the stretch removable pressure sensitive adhesive layer to form each medical article comprising a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions tapers towards a tip located distal from the central portion, wherein each terminal portion of the plurality of terminal portions comprises two edges leading to the tip, the two edges defining an included angle of about 90 degrees or less.

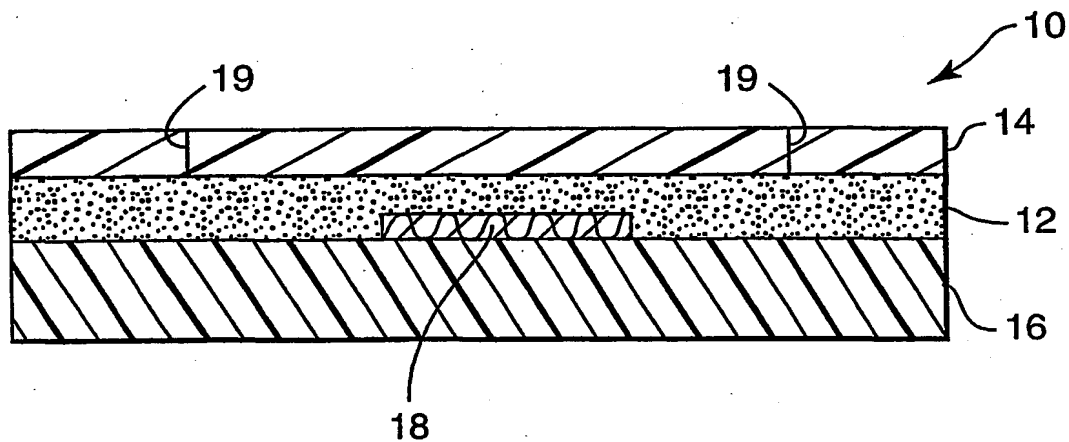
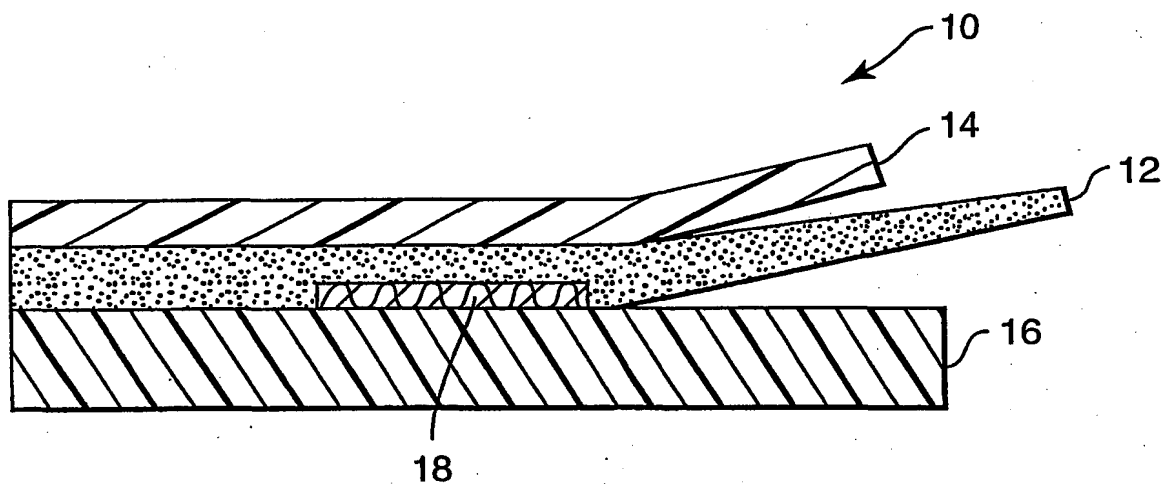
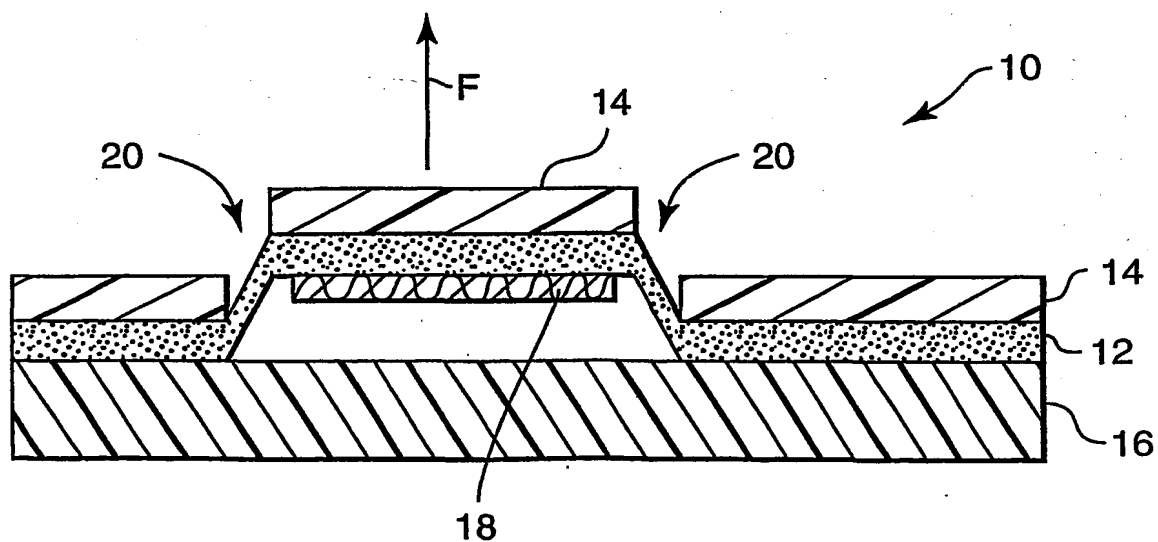
50. A method of making a medical article, the method comprising:
- 10 providing a backing;
- applying a stretch removable pressure sensitive adhesive to a major surface of the backing;
- converting the backing and the stretch removable pressure sensitive adhesive layer to form each medical article comprising a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions comprises a longitudinal axis, a tip located distal from the central portion of the backing along the longitudinal axis, a maximum width measured perpendicular to the longitudinal axis;
- 15 wherein each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions comprises a setback width measured at a setback distance of 5 millimeters towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 10 millimeters or less when measured perpendicular to the longitudinal axis, and further wherein the setback width is
- 20 about 2.5 millimeters or more when measured perpendicular to the longitudinal axis.

51. A method of making a medical article, the method comprising:
- providing a backing;
- 30 applying a stretch removable pressure sensitive adhesive to a major surface of the backing;

converting the backing and the stretch removable pressure sensitive adhesive layer to form each medical article comprising a plurality of terminal portions extending outwardly from a central portion, wherein each terminal portion of the plurality of terminal portions comprises a longitudinal axis, a tip
5 located distal from the central portion of the backing along the longitudinal axis, a maximum width measured perpendicular to the longitudinal axis;

wherein each terminal portion of the plurality of terminal portions tapers towards the tip such that each terminal portion of the plurality of terminal portions comprises a setback width measured at a setback distance that is 25% of
10 the maximum width towards the central portion from the tip along the longitudinal axis, wherein the setback width is about 60% or less of the maximum width when measured perpendicular to the longitudinal axis, and further wherein the setback width is about 10% or more of the maximum width when measured perpendicular to the longitudinal axis.

15

**FIG. 1****FIG. 2****FIG. 3**
1/5

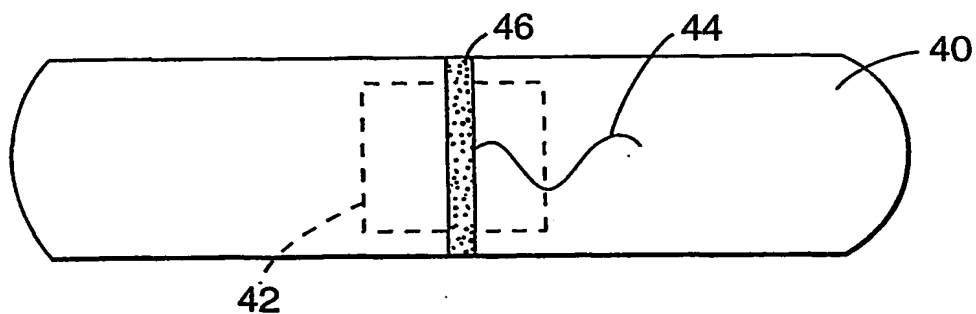


FIG. 4

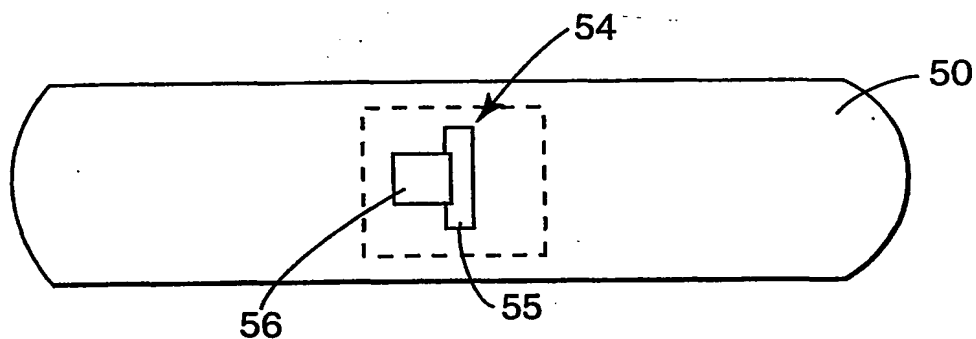


FIG. 5

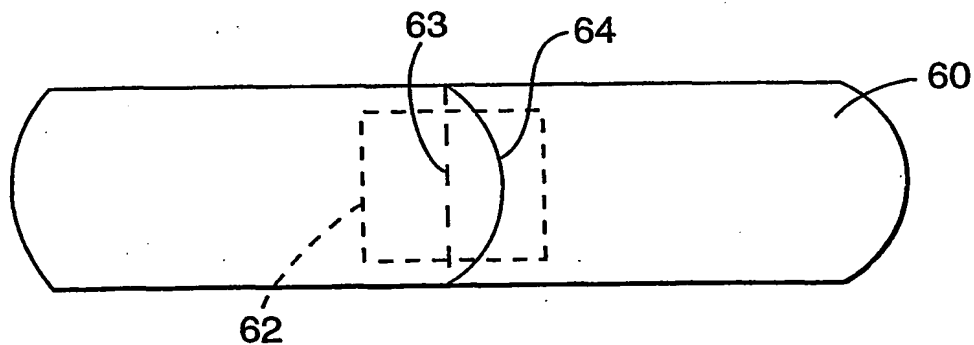


FIG. 6

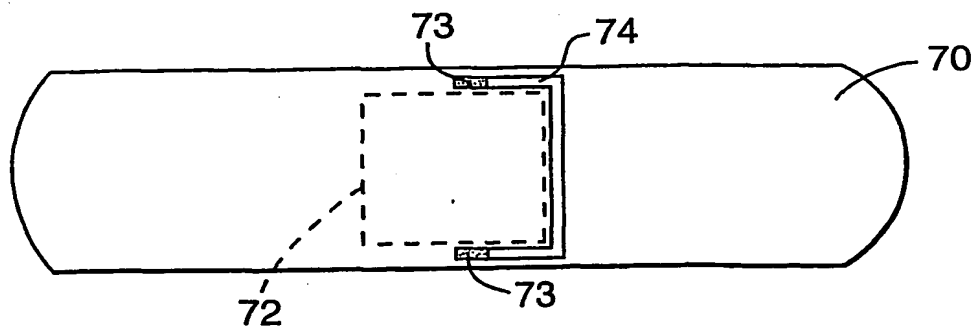
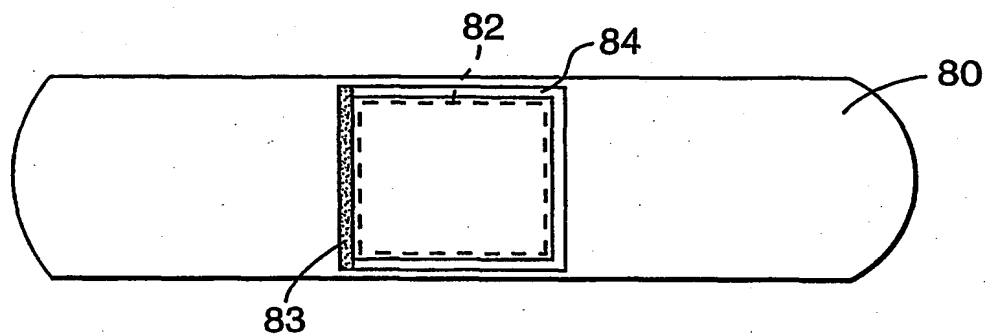
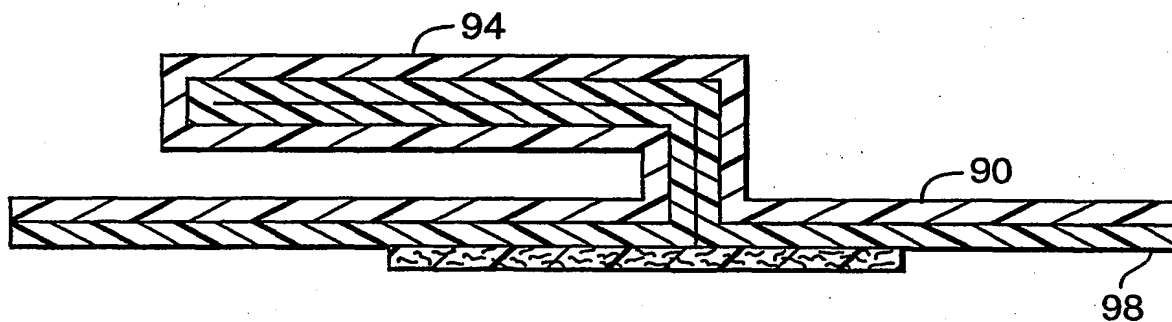
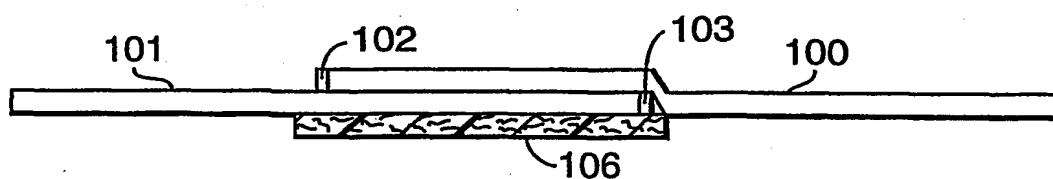
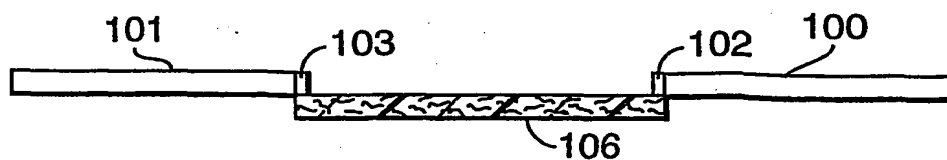
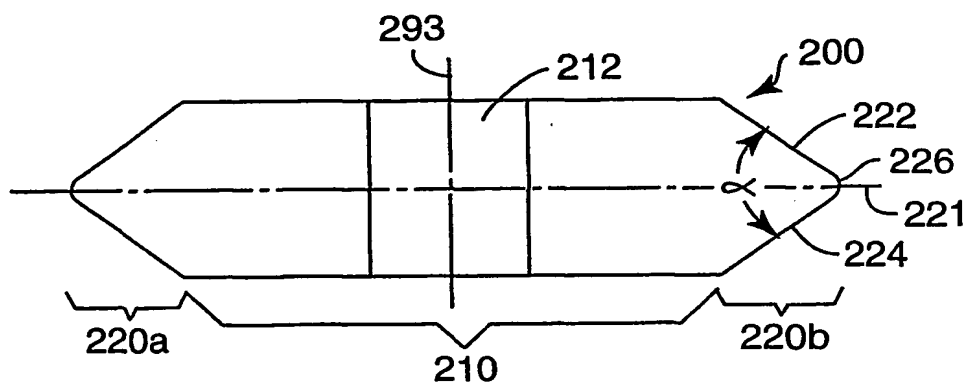
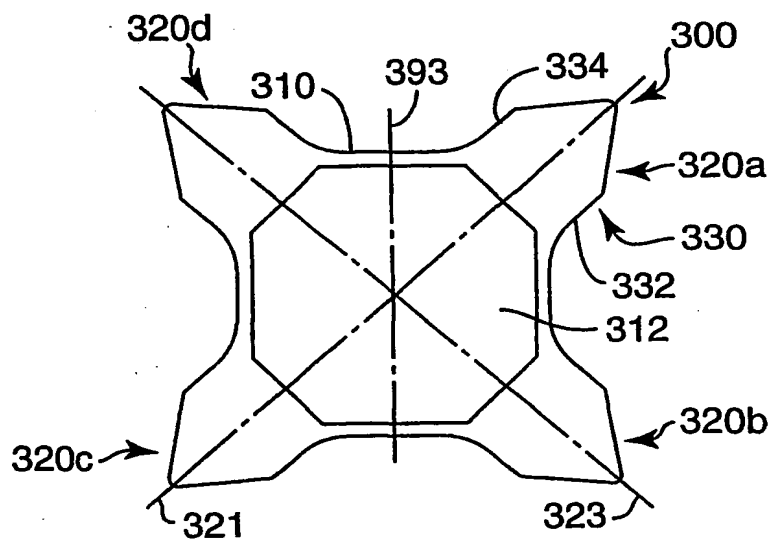
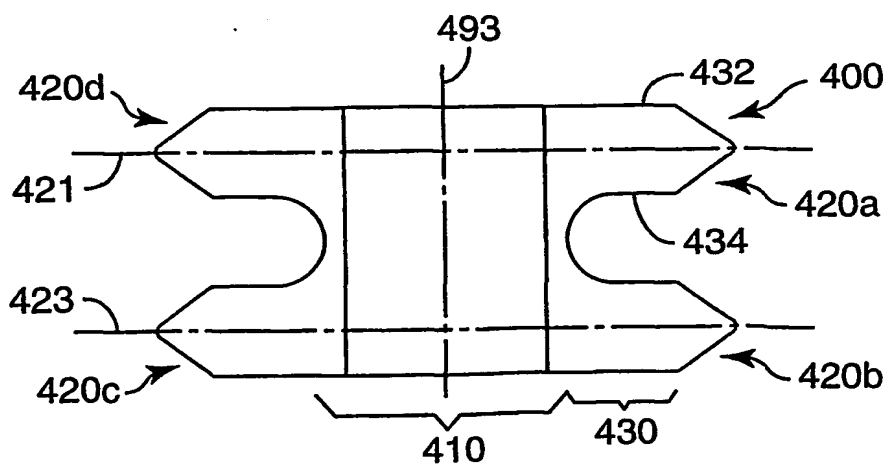


FIG. 7

**FIG. 8****FIG. 9****FIG. 10****FIG. 11**

**FIG. 12****FIG. 13****FIG. 14**

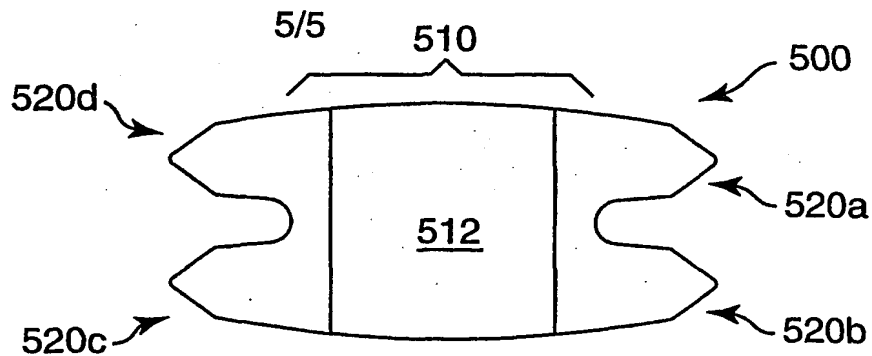


FIG. 15

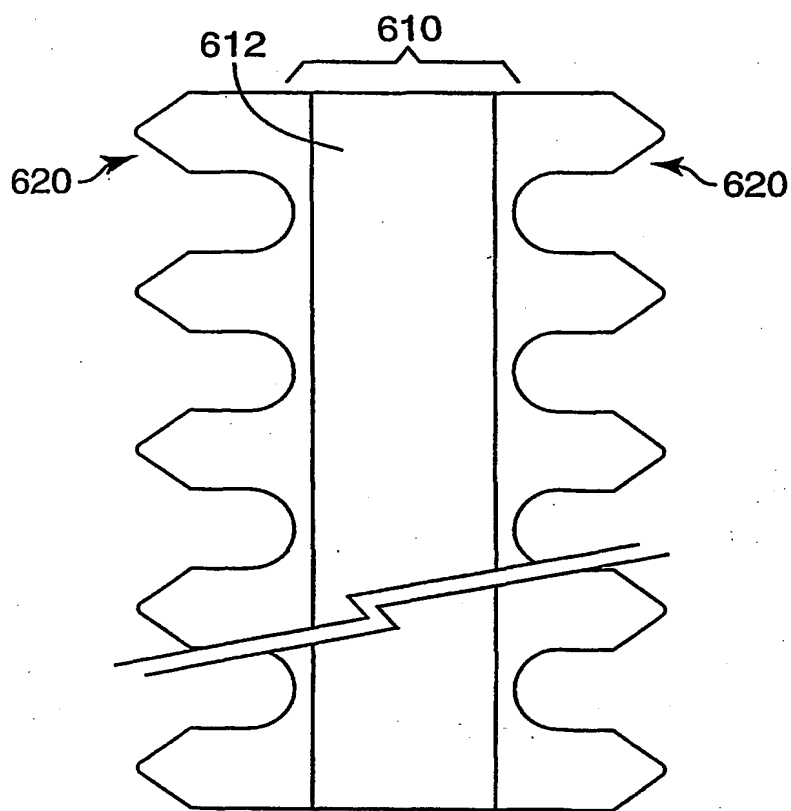
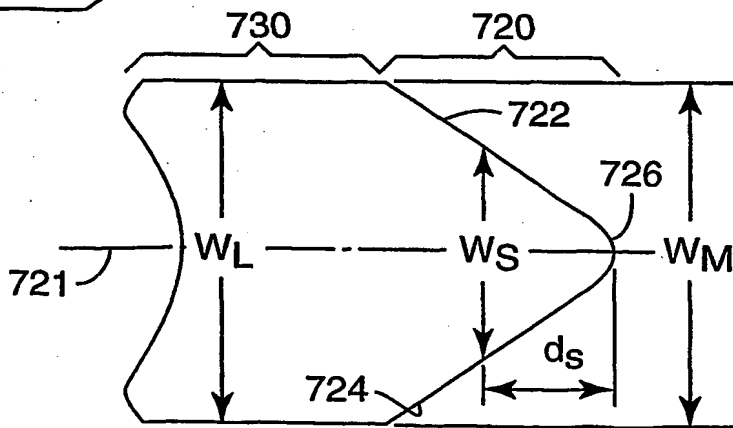


FIG. 16



5/5

FIG. 17

INTERNATIONAL SEARCH REPORT

Interna Application No

PCT/US 02/09221

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 A61F13/02

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 A61F A47G

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 747 027 A (BEIERSDORF AG) 11 December 1996 (1996-12-11) column 2, line 39 -column 3, line 1; figures ---	1,21,22, 31,40, 43,46, 49-51
A	EP 0 985 391 A (BEIERSDORF AG) 15 March 2000 (2000-03-15) column 1, line 11-17 column 2, line 5-30; figure 1 --- -/--	1,21,22, 31,40, 43,46, 49-51

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *G* document member of the same patent family

Date of the actual completion of the international search

3 July 2002

Date of mailing of the international search report

15/07/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Seabra, L

INTERNATIONAL SEARCH REPORT

Internal Application No
PCT/US 02/09221

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 3 232 291 A (PARKER LEON O) 1 February 1966 (1966-02-01) column 1, line 49-60 column 7, line 16-24; figures -----	1,21,22, 31,40, 43,46, 49-51
A	US 5 772 623 A (CONTE STEPHEN) 30 June 1998 (1998-06-30) abstract column 2, line 66 -column 3, line 3 column 4, line 6,7; figures -----	1,21,22, 31,40, 43,46, 49-51
A	EP 0 922 739 A (BEIERSDORF AG) 16 June 1999 (1999-06-16) claims -----	1,21,22, 31,40, 43,46, 49-51
A	US 5 989 708 A (KRECKEL KARL W) 23 November 1999 (1999-11-23) abstract column 6, line 12-27; figures -----	1,21,22, 31,40, 43,46, 49-51
A	US 4 024 312 A (KORPMAN RALF) 17 May 1977 (1977-05-17) abstract column 4, line 22-42; figures -----	1,21,22, 31,40, 43,46, 49-51

INTERNATIONAL SEARCH REPORT

Information on patent family members

Internat Application No

PCT/US 02/09221

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
EP 0747027	A	11-12-1996	EP 0747027 A2	11-12-1996
EP 0985391	A	15-03-2000	DE 19841550 A1	23-03-2000
			AU 4463499 A	16-03-2000
			EP 0985391 A2	15-03-2000
US 3232291	A	01-02-1966	NONE	
US 5772623	A	30-06-1998	NONE	
EP 0922739	A	16-06-1999	DE 19755222 A1	24-06-1999
			AU 8936198 A	01-07-1999
			EP 0922739 A1	16-06-1999
US 5989708	A	23-11-1999	US 5516581 A	14-05-1996
			US 5672402 A	30-09-1997
			AU 654315 B2	03-11-1994
			AU 9157591 A	22-07-1992
			BR 9107249 A	22-02-1994
			CA 2096935 A1	21-06-1992
			DE 69124626 D1	20-03-1997
			DE 69124626 T2	10-07-1997
			EP 0563272 A1	06-10-1993
			ES 2097902 T3	16-04-1997
			HK 1007761 A1	23-04-1999
			JP 3063915 B2	12-07-2000
			JP 6504077 T	12-05-1994
			KR 185422 B1	01-04-1999
			MX 9102731 A1	31-01-1994
			WO 9211333 A1	09-07-1992
			ZA 9110081 A	27-01-1993
US 4024312	A	17-05-1977	AU 518205 B2	17-09-1981
			AU 2629277 A	04-01-1979
			BR 7704063 A	11-07-1978
			CA 1080559 A1	01-07-1980
			DE 2728346 A1	05-01-1978
			ES 459978 A1	01-12-1978
			FR 2355893 A1	20-01-1978
			GB 1559933 A	30-01-1980
			IT 1079059 B	08-05-1985
			JP 1305861 C	13-03-1986
			JP 53000235 A	05-01-1978
			JP 60031233 B	20-07-1985
			NL 7706854 A ,B,	28-12-1977
			NZ 184296 A	08-06-1979
			PH 13292 A	04-03-1980
			ZA 7703754 A	31-01-1979

This Page Blank (uspto)